Walker, Michigan, U.S.A. 49534-7564

USER'S OPERATING AND INSTRUCTION MANUAL

MODEL 1908MX2

AUTOMATED PACKAGING SYSTEM

1908S20078CV

OLIVER®

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QUICK SPECS

Weight	**330 lbs**
Overall Dimensions	**30” W x 64” L x 50” H**
Loading Station	**3 tray carriers**
Electrical	**1 phase, 60 Hz, 115 VAC, 15 amps**

INTRODUCTION AND DESCRIPTION

The *OLIVER Model 1908 Lidder* has been designed and manufactured to provide a high quality machine that is a cost effective approach to producing film lidded trays. The machine can be operated with a 120 V.A.C. outlet. The Model 1908 is an automated system capable of producing a high volume, but it is easy to operate and requires minimal space.

The machine consists of a conveyor system that transports the filled trays; a film feed system, a heated platen and a film cutter unit. These are all packaged together in a stainless steel framework that also houses all the necessary controls. The conveyor is intermittent motion and is capable of running speeds of 20 to 27 packages per minute.

INSPECTING

MODEL 1908

Upon receipt of Machine, inspect the exterior for damage. If damage is noted, Indicate damage on the **Freight Bill** and immediately contact the freight Carrier and notify them of the damage. Have a freight claim filed. **This must be done at the Recipient's location and not at the Shipper's Location.**

Remove the tie-downs that hold machine to the skid. Lift the machine off the skid in a safe manner. Remove tape and tie bands that were used to hold components for shipment.

SAFETY

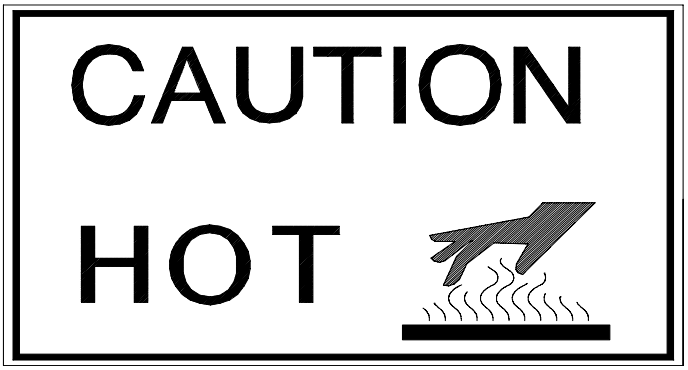
Various safety devices and methods of guarding have been provided on this machine. Do not operate the machine with guards removed and do not tamper with safety devices. It is essential that machine operators and maintenance personnel observe the following safety precautions. Improper installation or operation of this equipment may cause injury to personnel or damage to equipment.

- Before operating the *OLIVER Model 1908 Lidder* read through this manual. Never allow an untrained person to operate this machine

WARNING

- **WARNING PINCH POINT: Keep hands out of machine.** Always be sure the machine has been unplugged from power before cleaning or servicing.

- **CAUTION HOT:** The heater platen and parts around it are very **HOT!** Caution must be used to protect yourself and others.



- In addition to these general safety instructions, follow the specific instructions given throughout this manual.

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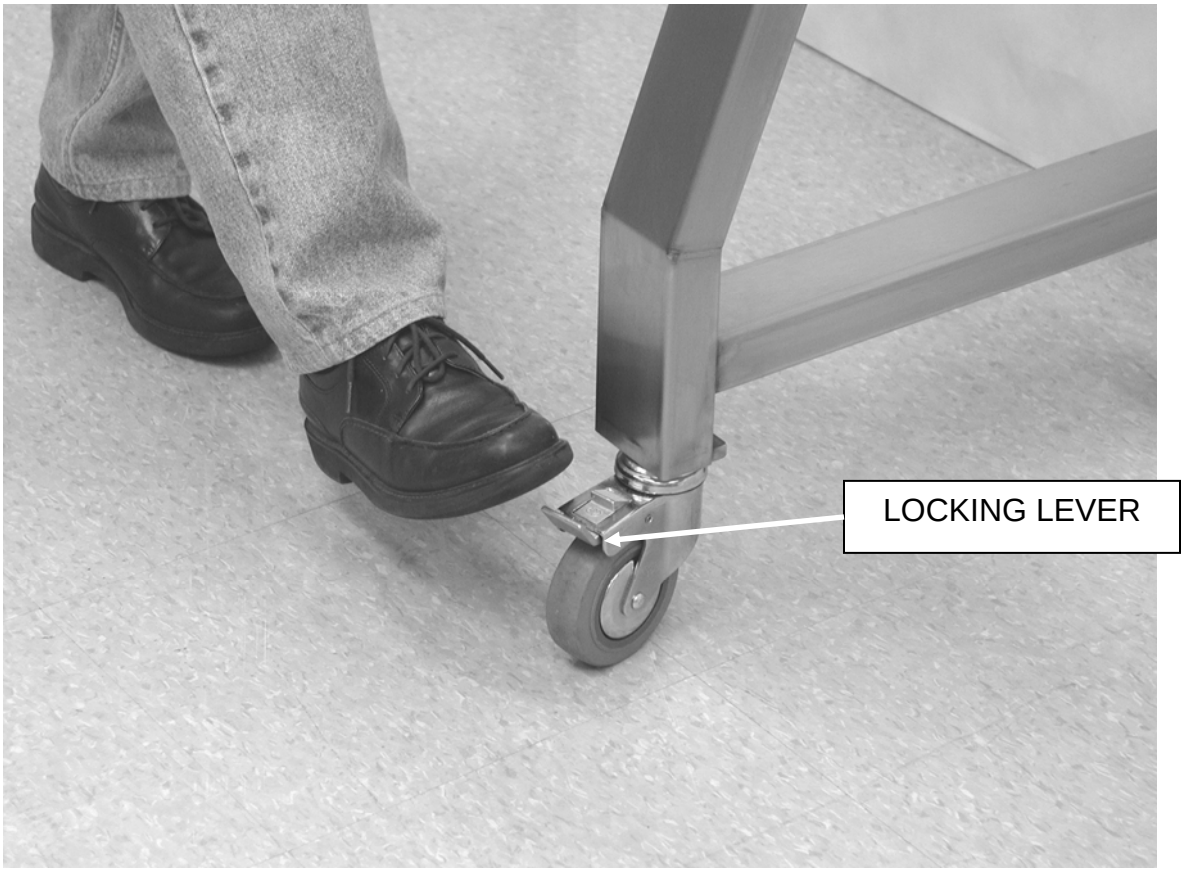
MACHINE PLACEMENT AND UTILITIES

MODEL 1908

Decide on a suitable location for the machine. This location should have ample room to work around all sides of the machine. Once the machine is in the location where it will be used, the brakes on the casters should be locked by stepping down on the brake locking lever. To unlock, lift the lever with your foot. Do not attempt to move machine with casters in locked position.

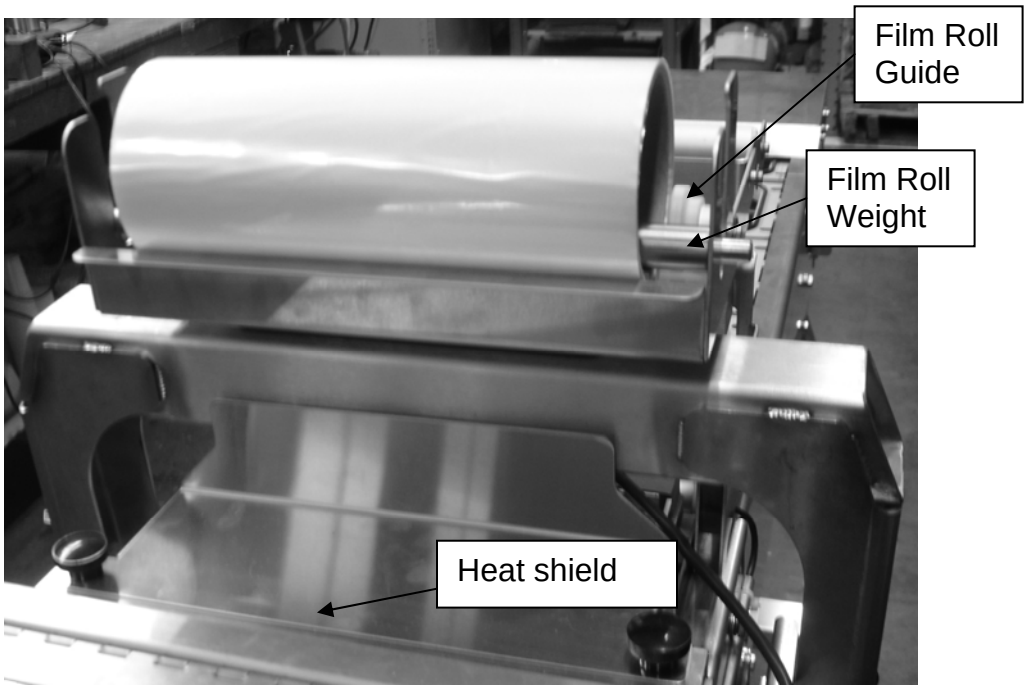


The machine operates on 120 V.A.C., 60 Hz, 15 Amp electrical power. It is recommended that this power be supplied by an overhead drop to prevent the cord from becoming a trip hazard.

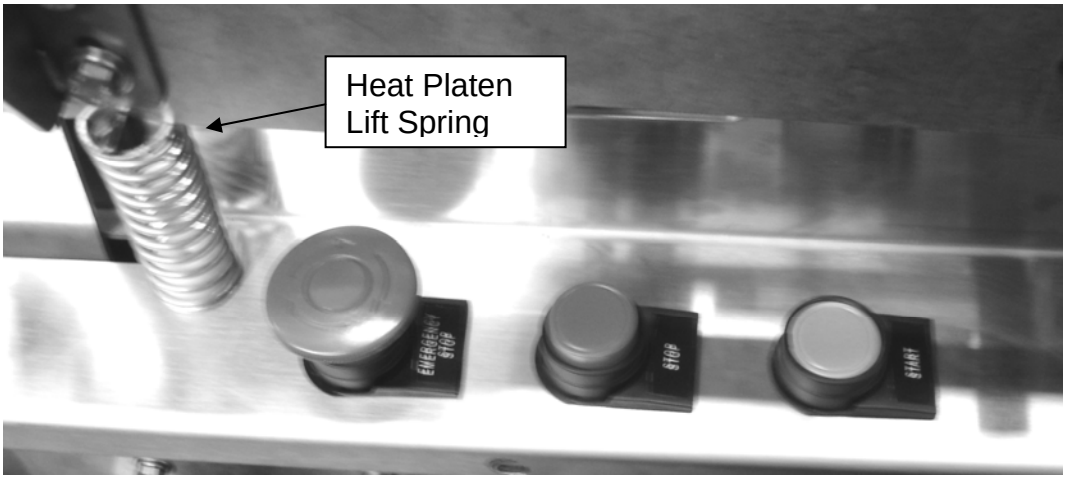
MACHINE COMPONENTS

Before proceeding further, take a moment to familiarize yourself with the identification of the machine components as shown in the illustrations below.

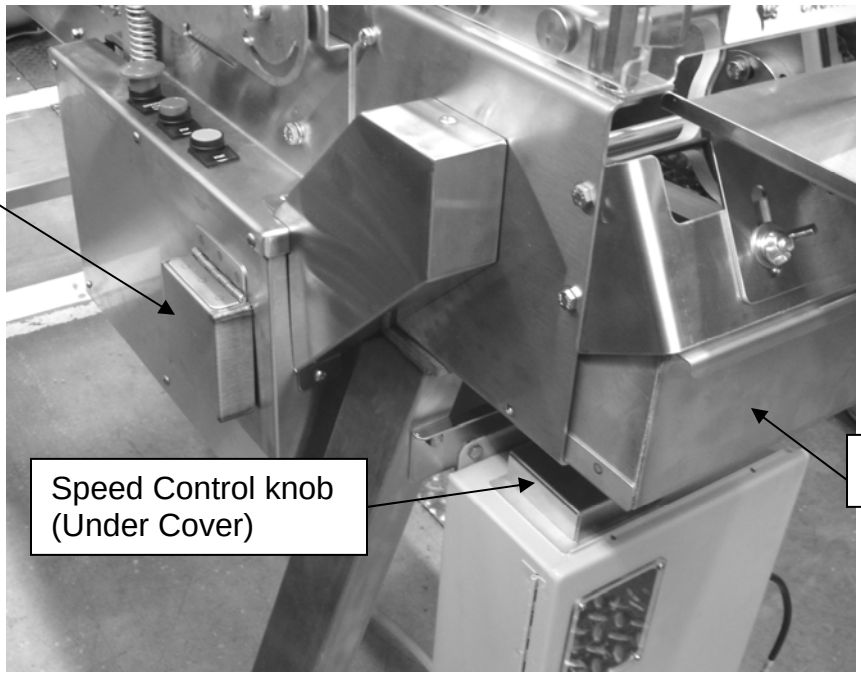
Film Roll Holder with Film Roll and Roll Weight Installed.

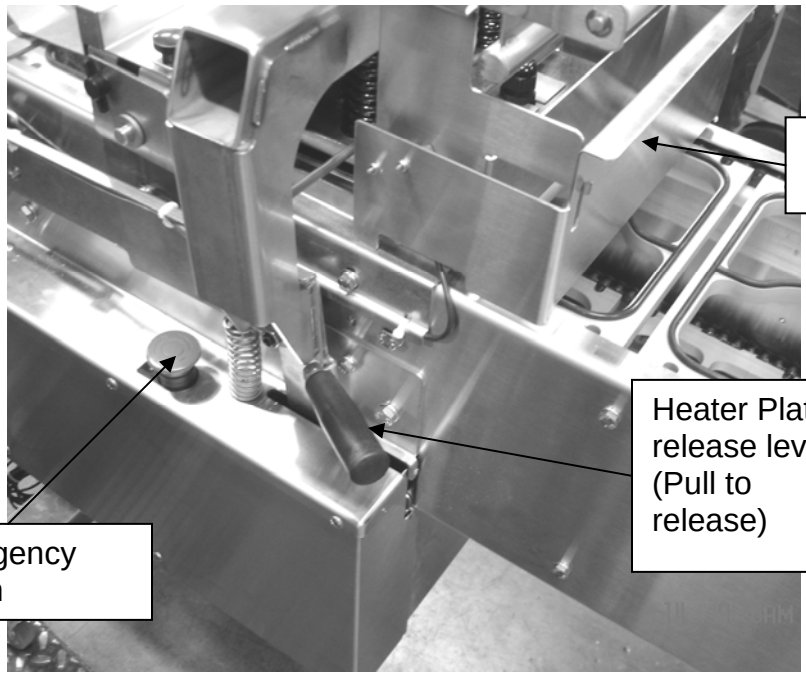


Emergency Stop, Stop, and Start Buttons

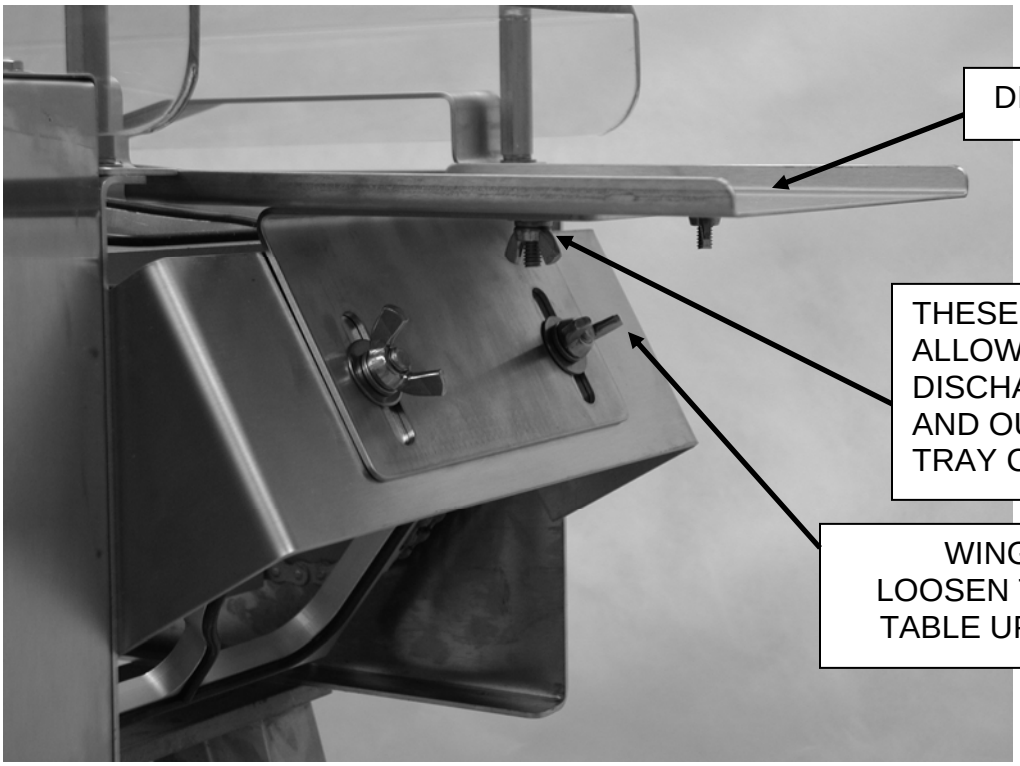


Drive and Platen Release Locations and Speed Control Location

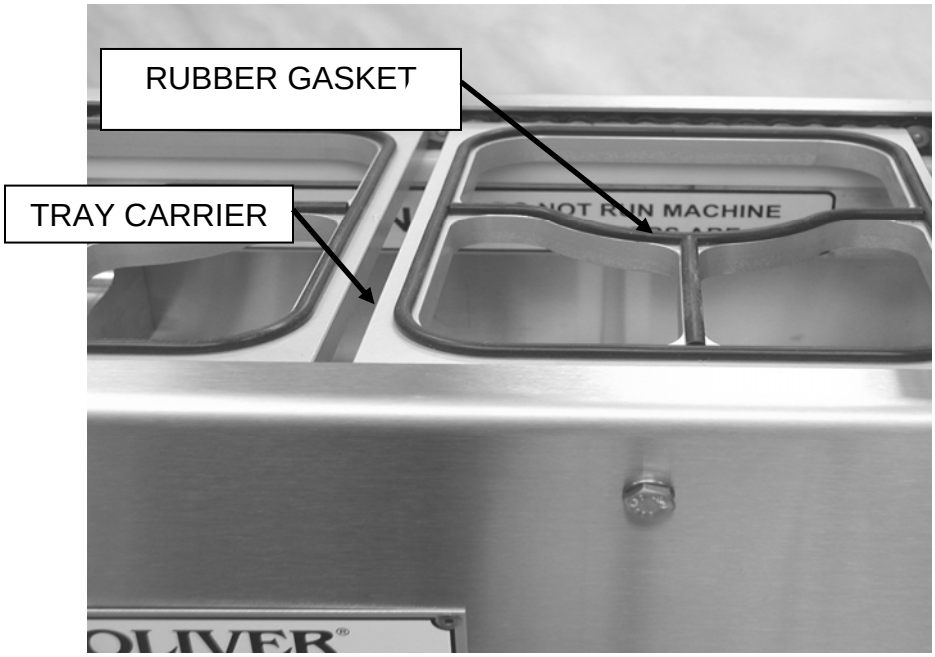




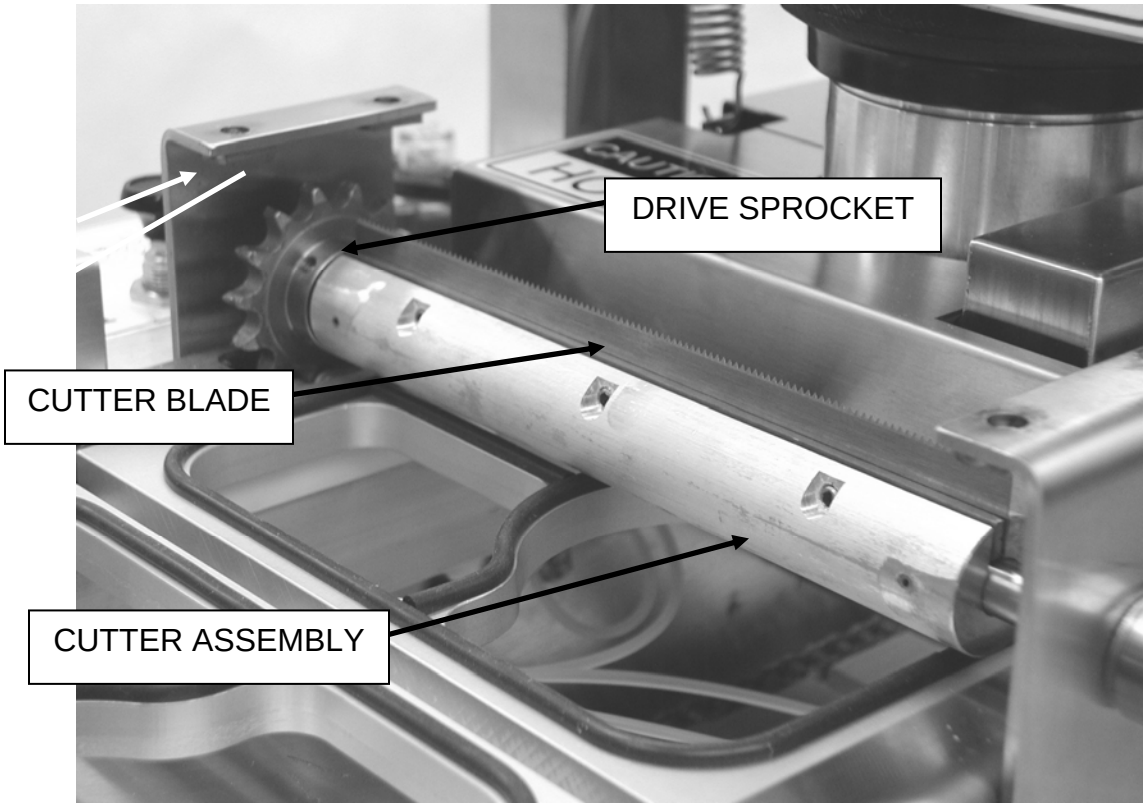
Out feed or discharge area


DISCHARGE TABLE
THESE WING NUTS ALLOW FOR MOVING THE DISCHARGE TABLE IN AND OUT TO CLEAR THE TRAY CARRIERS
WING NUTS LOOSEN TO ADJUST TABLE UP OR DOWN

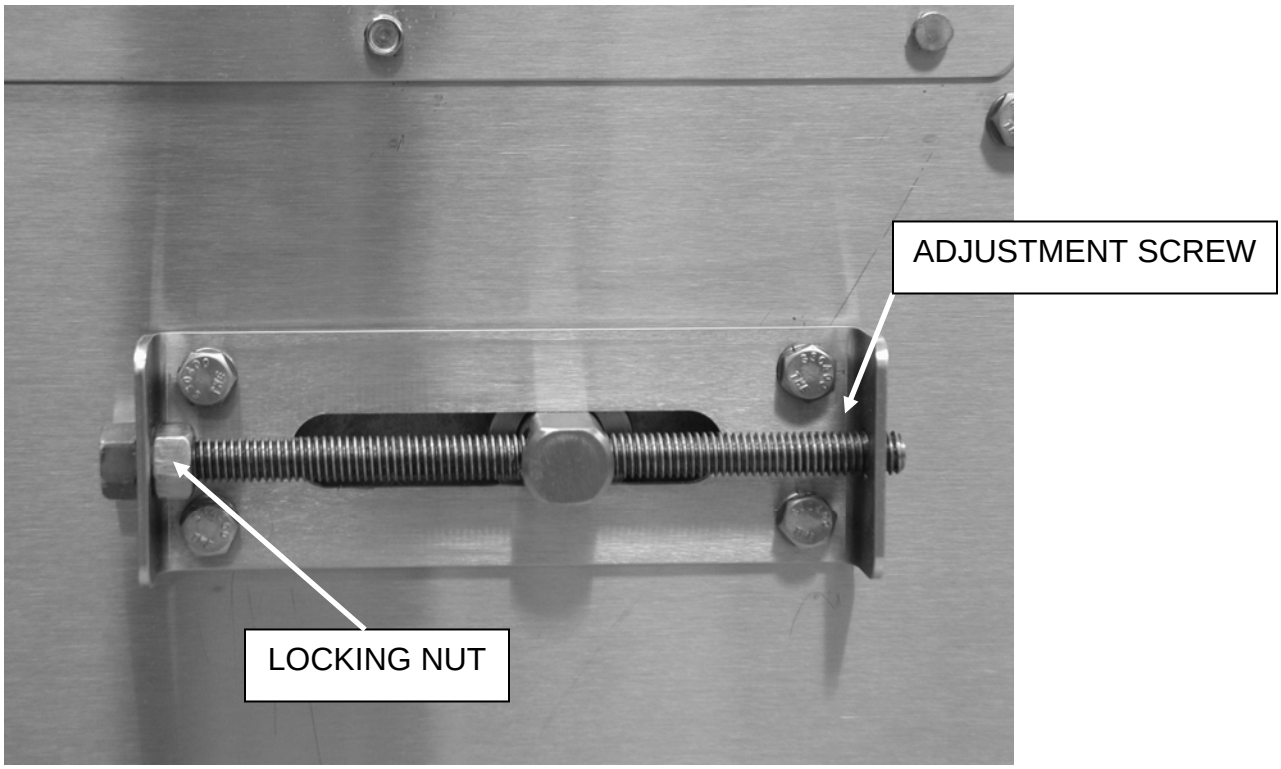
Tray Carriers



Film Cut-Off



Conveyor Chain Tension Adjustment Mechanism



START-UP & OPERATION

To turn the machine on, plug in the power cord and wait 15 minutes to allow the heated platen to reach operating temperature before attempting to seal trays.

Run the machine without trays and film to make sure everything is cycling properly.

1. VERIFY THE CONVEYOR IS READY TO OPERATE: Remove any extra items that may have been placed on the conveyor and verify people are clear of the trays and tray carriers. The guards (in-feed gate and clear exit cover) must be in place and the emergency stop buttons must be in the up position (twist and allow the button to pop up to reset).

2. VERIFY THE SEALING PLATEN IS CONNECTED TO THE PULL-DOWN ARMS: Lift the black handles and hook the roller on the platen arch. This may be left undone if it is desired to run the conveyor without operating the sealer.

3. PUSH THE GREEN “RUN” BUTTON.

4. PUSH THE RED “STOP” BUTTON TO STOP THE MACHINE WITH THE SEALING PLATEN UP (NOT PRESSING ON A TRAY OR TRAY CARRIER).

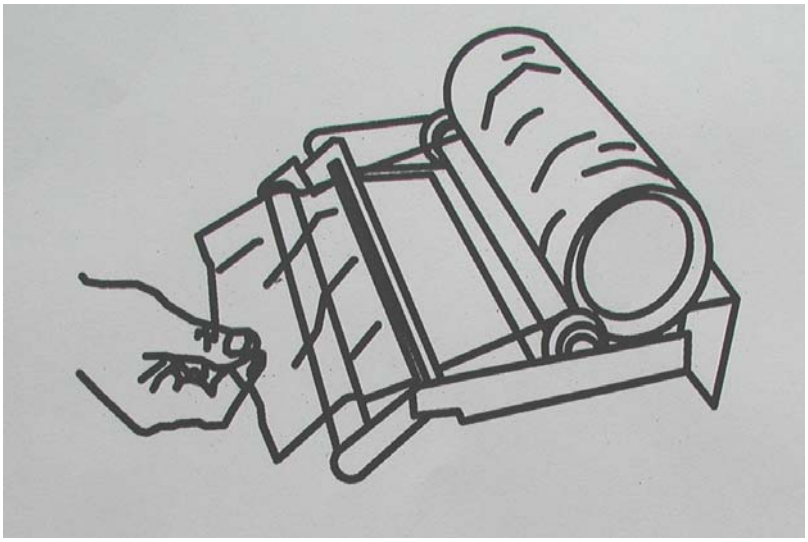
NOTE: USE THE EMERGENCY-STOP BUTTONS OR THE SAFETY GATE SWITCHES TO STOP THE MACHINE IN EMERGENCY SITUATIONS ONLY. These switches act immediately and do not wait for the sealing cycle to finish. This will leave the heater in contact with the tray resulting in over-heated packaging materials. Stopping the machine improperly will result in a shortened machine life.

5. TO CHANGE THE CONVEYOR SPEED: Adjust (turn) the black knob on the top of the electrical box (lift the small stainless steel cover to access).

IMPORTANT NOTES

- **Never run the machine with trays without film.** Doing so can possibly cause a jam because the trays can stick to the heated platen and be pulled out of the tray carriers.
- Adjusting the speed of the conveyor will also change the dwell time of the sealer. **Excessively slow speeds will result in excessively sealed trays.**
- **If the conveyor becomes jammed**, **stop the conveyer and turn the power off**. The conveyor drive release knob may be pulled to allow manual movement of the conveyor to aid removing jammed materials.

6. Load the film on the film stand as shown on the film-threading diagram located on the machine and also shown in the diagram below.



NOTES

- The adhesive side of the film can be determined by pinching a fold and rubbing the lid material against itself. Test both sides of the lid. The rough or tacky side of the lid will be the adhesive side. The film supplied by Oliver is wound with the adhesive side toward the inside of the roll. If the film is loaded in accordance with the **"FILM FEED"** diagram it will be positioned properly for applying the adhesive side of the film to the flange of the tray. If the film is loaded improperly, it can cause the adhesive side to come in contact with the heated platen and the film to stick to the heated platen. If this happens, the platen will need to be cleaned.

- To thread the film through the machine, pull enough film off the roll so that you can insert it into the slot between the tray carrier that is partially under the film stand and the carrier that is upstream from that. After the film is hanging down underneath the tray carrier, reach through the tray carrier and pull the film down so that it touches the tray carriers underneath that are returning to come back up on top. Then insert a tray into the tray carrier next to the film and cycle the machine one time. This should seal the film to that tray and you can now fill the rest of the conveyor with filled trays and begin running.

- The film dancer bar must move freely up and down.

- If you miss putting a tray in the machine it will not cause a problem, but the film will be sealed to the top of the empty tray carrier. Let the machine continue to run until that tray carrier goes around the bottom of the conveyor and comes back up on top, then remove the piece of film.

- It is important that the roll of film is centered on the conveyor. There are white plastic film guides on either side of the film roll. These guides can be adjusted from side-to-side by pushing them with your hand. If the film is not centered, move both guides toward the side that the film needs to go to. It may take a little bit of running time before you can tell if the film is in the correct position.

7. Place filled trays in tray carriers. Take care to avoid spilling food product on the flange of the tray. Contamination of the flange can result in poor heat seals.

8. After a few trays come out of the machine, stop and inspect the acceptability of the seals. If the seals are not acceptable or the trays do not come out of the machine smoothly, refer to the trouble shooting guide.

9. The machine can be stopped at any time by pushing the stop button down. When started again, the machine will pick up sealing where it left off.

NOTE

- **IT IS NOT RECOMMENDED TO LEAVE THE MACHINE PLUGGED IN IF IT IS GOING TO BE OUT OF OPERATION FOR AN EXTENDED PERIOD OF TIME.**

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TECHNICAL SPECIFICATIONS

Model 1908

Tray Capacities: 6-3/8" (162mm) by 8.5" (216mm) maximum top-outside-dimensions of the tray.
Temperature Range: Factory preset to approx. 300 degrees F.
Weight: 330 LBS.
Electrical: 120 VAC, 15 Amps, Single Phase, and 60 Hz
Air Requirements: 6 CFM @ 80 PSI

Machine Dimensions: 17" (43.2 cm) Wide x 64" (162.5 cm) Long x 45" (114.3 cm) High

CLEANING AND MAINTENANCE

WARNING

Disconnect the power from the Model 1908 and allow the unit to cool before performing cleaning and/or maintenance procedures.

These cleaning recommendations are not meant to replace or supersede plant-standard manufacturing procedures or regulatory requirements. **Do not immerse, hose down, pressure wash, or otherwise soak electrical switches, electrical control box, mechanical drive box, and electrical connections. Avoid getting these areas wet. If your cleaning procedure involves liquid amounts greater than the use of a damp cloth, protect these areas by shielding with plastic bags.**

1. Heater Platen Cleaning:

CAUTION

- **CAUTION HOT:** The platen and surfaces around it may be very **HOT!** Care must be taken to protect yourself and others. If the platen will be cleaned while it is still hot make sure hand protection is used to prevent skin contact with the platen.

  If food product comes in contact with the surface of the platen it tends to burn on and become hard. This results in an irregular surface on the face of the platen that can result in poor seals. If this happens, it will be necessary to remove this burnt on food material.

  1.1. Remove the In-feed guard.

  1.2. Tip the film roll holder forward until it is resting on the side rails of the machine.

  1.3. Remove the discharge cover and heat shield by removing the 4 black plastic screw knobs on top of the covers and lift the covers off.

  1.4. Release and tip the heater platen up by pulling the large black handles and rotating the heater platen upwards until it is against the stops. The bottom of the heater plate will be easily accessible.

  1.5. Clean any food residue off the heater platen. When cleaning the surface of the platen care must take to avoid scratching or gouging the surface. **DO NOT SCRAPE THE SURFACE OF THE PLATEN WITH SHARP OBJECTS AND AVOID THE USE OF METAL TOOLS**. Instead use a plastic or soft-metal scouring pad such as Scotch Brite® or Chore Boy® brands provide a safe and effective means of cleaning the heated platen. Wipe all surfaces with a sanitizing agent after cleaning.

2. Tray Carrier Cleaning:

The tray carriers should be removed and cleaned daily. It is better to remove them for cleaning rather than trying to clean them in the machine. The tray carriers can be placed in your dishwasher for cleaning if you desire. Care should be taken so that the rubber gaskets do not become damaged.

2.1. Disconnect the conveyor from the drive unit by lifting the cover on the side of the machine and pulling the knob out. The knob will stay out if it is twisted ¼ turn while pulling. This allows the conveyor to be moved manually.

The carriers should be removed in the middle of the in-feed area on the top of the conveyor.

2.2. Lift up on two tray carriers next to each other and push one to one side while pulling the other it to the other side. This spreads the chains so the pins can be disengaged. Completely remove the two carriers as shown.

The picture below shows how to remove the tray carriers.

2.3. As the carriers are removed, the conveyor must be pulled forward to keep getting to the remaining carriers. To move the conveyor forward, grasp a tray carrier toward the infeed-end of the machine and pull the conveyor forward. This must be done with the conveyor disconnected from the drive (step 2.1).

2.4. Wipe all surfaces with a sanitizing agent after cleaning.

2.5. Replace the tray carriers after cleaning the remainder of the machine.

Note: Look for a white painted chain link to center on the side of the first tray carrier re-installed to get the tray carrier/ chain timing correct.

Note: When replacing the tray carriers, it is extremely import to make sure that all four pins on the conveyor chains are fully engaged in the holes of the tray carrier. If the tray carriers are put in on an angle because the pins are not engaged on one side, it could cause damage to the cutter assembly.

2.6. Re-engage the conveyor drive by twisting the release knob until it snaps in. Move the conveyor manually until the pin locks in and prevents further movement.

3. Clean the remainder of the machine:

3.1. Remove the two bottom pans by sliding them toward the discharge end of the machine. Note: the pans may need to be jostled up and down slightly to get them over bolt heads and other obstacles.

3.2. Clean the cutter assembly with a mild cleaner or sanitizing solution and a damp cloth.

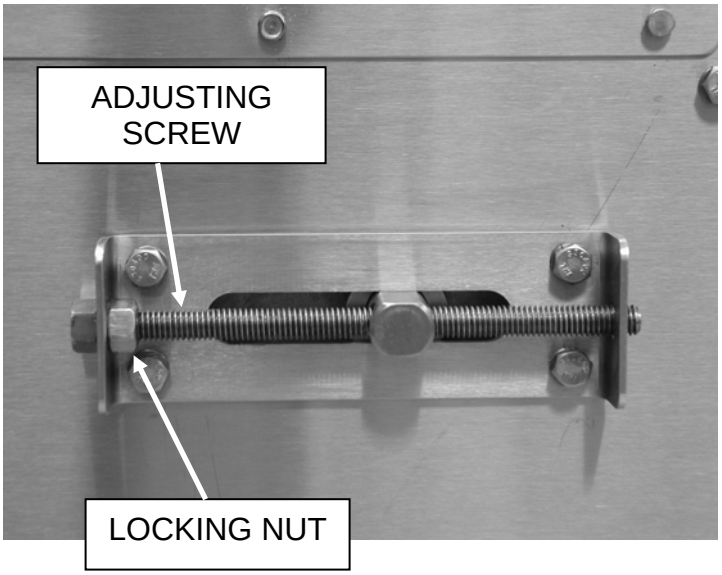
NOTE

The use of plastic or soft-metal scouring pads such as Scotch Brite® or Chore Boy® brands provide a safe and effective means of cleaning the cutter assembly. Wipe all surfaces with a sanitizing agent after cleaning.

3.3. Clean the pans and remaining surfaces of the machine with a mild cleaner or and a damp cloth. Wipe all surfaces with a sanitizing agent after cleaning.

4. Conveyor Chain Maintenance
   4.1. Once a month the conveyor chains should be lubricated with vegetable oil such as cooking spray. If you use hose-down cleaning, this should be done twice a month.

   4.2. Once a month the conveyor chains should be checked for proper tension. The tension can be checked by lifting the lower tray carriers at the middle of the machine. If you can easily lift them up more than 3 inches, the chains are too loose and should be tightened by adjusting the tensioners at the infeed-end of the machine. Loosen the locking nuts and turn the adjusting screws clockwise to tighten the chains then retighten the locking nut. It is important to adjust both sides equally. The easiest way to do this is to count the turns that you tighten one side and then do the same on the other side. The best method is to adjust each side in ¼ turn increments and then recheck the chain tension.



TROUBLESHOOTING

There are no user serviceable parts on your *OLIVER Model 1908 Lidder* except for the cutter blade. Should you experience problems with your machine call the **Oliver Products Company 24 Hour Emergency Service number @ 1 800-253-3893**. **Please have the serial number of your machine available to give to the Customer Service representative.**

Before calling for assistance please check the list below to see if the problem you are experiencing is listed. If it is, try the corrective action items listed for that problem before calling for assistance.

OPERATION ISSUES:

Symptom:	Corrective Action:
Machine does not power-up (does not run and/or the heater platen does not get hot)	1. Verify the machine is plugged in to a working outlet. 2. If the platen does not heat, unplug the power and remove and inspect the fuse (located in the electrical panel, see section 4). Replace if necessary (see parts list).
Machine receives power, but the conveyor does not move when the start button is pushed.	3. Verify the two e-stop buttons are not engaged (pushed down). Twist the button to release it to the ready to run position. 4. Verify the in-feed guard is installed in the correct position (stainless steel gate hung in front of the heater platen). 5. Verify the discharge cover is installed correctly (plastic cover). 6. Verify the speed control knob is turned to 75% to 100% of the speed range.

Conveyor does not move when the start button is pushed and steps 1-4 (above) have been taken.	7. Turn the speed up to 100%. Look in the window of the electrical box under the conveyor out-feed. A green or red light should be visible. --A green light indicates the motor is receiving power and should be able to run. If only a green light is visible, go to step 12. --A red light indicates a mechanical jam— turn off the main power immediately. Go to step 8. --No light indicates power is not available to the motor because a guard, e-stop switch, or main power switch is tripped. Go to step 13.
A mechanical jam is preventing the conveyor from moving as indicated by a red light in the electrical box window.	8. Mechanically disconnect the indexer drive from the conveyor by pulling the disconnect knob and turning it 90 degrees (1/4 turn) so it stays out. 9. Mechanically disconnect the platen by pulling the large black plastic handles. Allow the platen springs to hold the platen up off the conveyor, but ***do not*** remove guards and lift it as you would for cleaning. 10. Manually pull the conveyor. If it pulls freely, the problem is in the transmission box (Call for service). If the conveyor does not move, look for a jammed tray, an incorrectly installed and/or wedged tray carrier, excessive food build-up, excess film wrapped around a conveyor part or the cutter, or excessive chain tension. 11. If no correctable cause is found for the jam, call for service.

The drive system appears to be working correctly as indicated by a green light in the electrical box window, but the conveyor does not move.	12. Verify the drive is mechanically engaged with the conveyor—Check the disconnect knob—make certain it is not pulled out (twist the knob and allow it to snap in). Give the conveyor a pull until it "hooks up" (cannot be manually moved further).
The drive system is not receiving power as indicated by the absence of lights visible in the electrical box window.	13. Recheck steps 1-6. If step 13 does not remedy the problem, call for service.

SEALING and TRAY BEHAVIOR ISSUES:

Poor seal quality	1. Verify that the platen is heated by placing your hand near the platen and try to detect if there is heat radiating out from it-DO NOT TOUCH THE PLATEN 2. Check to see if the platen is dirty 3. Check rubber gasket on tray carriers for damaged or missing pieces 4. Check to see that the film is centered on the tray 5. Check to see that the heat seal dwell is set properly 6. Make sure that the tray flanges are not contaminated with product 7. Verify the film is routed so the adhesive coated side is oriented against the tray. See "Start-Up and Operation" section step 6.

Film does not cut	1. Inspect the cutter blade for wrapped film- You must remove the cutter guard to do this and if there is film wrapped around it the film must be cut away and pulled off- THE CUTTER BLADE IS SHARP, DO NOT TOUCH-REMOVE ELECTRICAL POWER PRIOR TO REMOVING GUARD. 2. Inspect to determine if the cutter blade is present. 3. Inspect to determine if the cutter blade is dull. 4. Inspect to determine if the cutter blade is dirty.
Film is not centered on tray	Adjust the plastic guides on the film holder so that the film is centered over the trays
Trays do not exit the machine smoothly.	Adjust the position of the discharge table. Loosen the thumb screws and move the table. Make the table height slightly lower than the bottom of the trays as they exit the conveyor. Keep the gap between the table top and the conveyor small enough to prevent the trays from tipping down between the conveyor and the discharge table. (Reference the labeled photograph in the “Machine Components” section of this document.) Verify the film is being cut effectively, if not, see above.

MAINTENANCE CHECK LIST

WARNING: DISCONNECT AND LOCK OUT ELECTRICAL CORDS BEFORE PERFORMING MAINTENANCE & CLEANING

1	CLEAN TRAY CARRIERS & CHAIN	D
2	INSPECT RUBBER GASKETS IN TRAY CARRIERS	D
3	REMOVE/CLEAN/REPLACE BOTTOM PANS	D
4	CHECK HOT PLATEN	D
5	OIL CHAIN	M
6	INSPECT & CLEAN CUTTER BLADE	W
7	FILM DANCER BAR IS MOVING FREELY	D
8	OIL DRIVE CHAINS	6M

D = DAILY
W = WEEKLY
M = MONTHLY
6M = EVERY 6 MONTHS

NOTE: REFER TO MANUALS FOR INSTRUCTION

6401-3004

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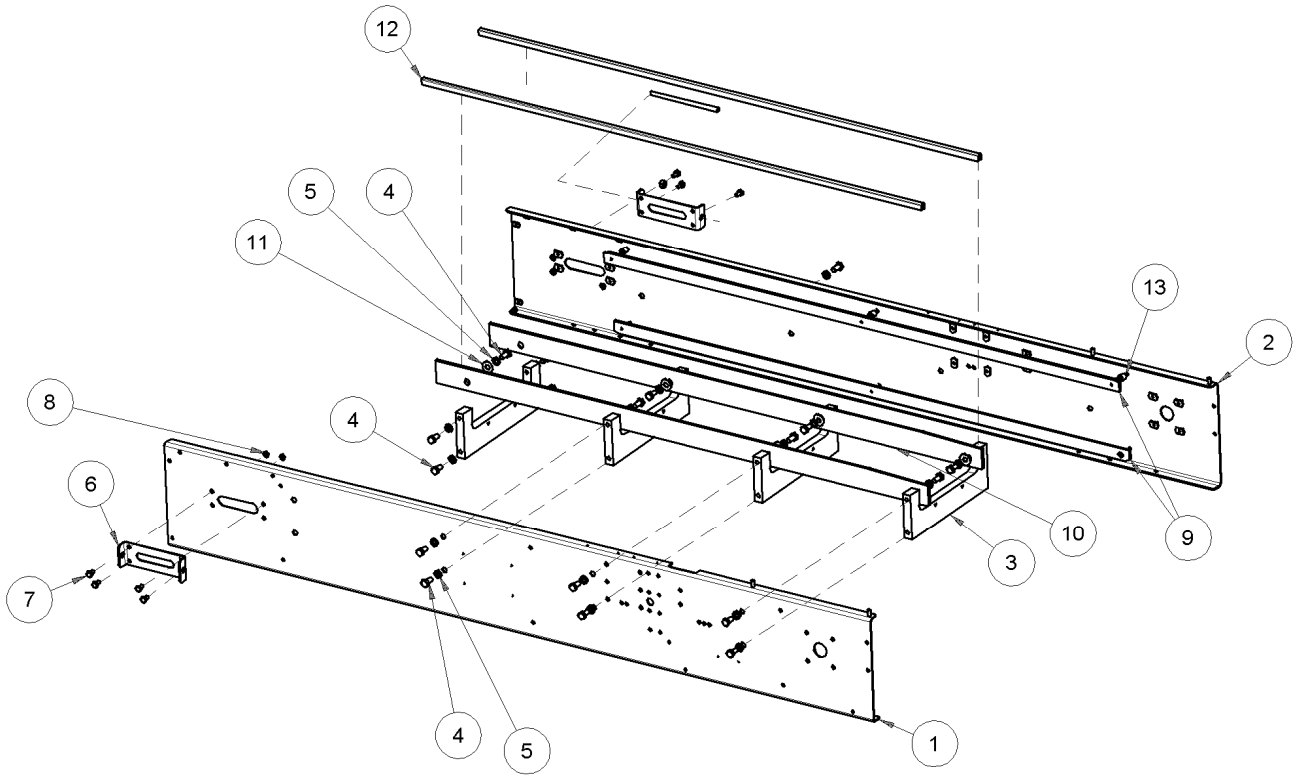
MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (BASE FRAME)



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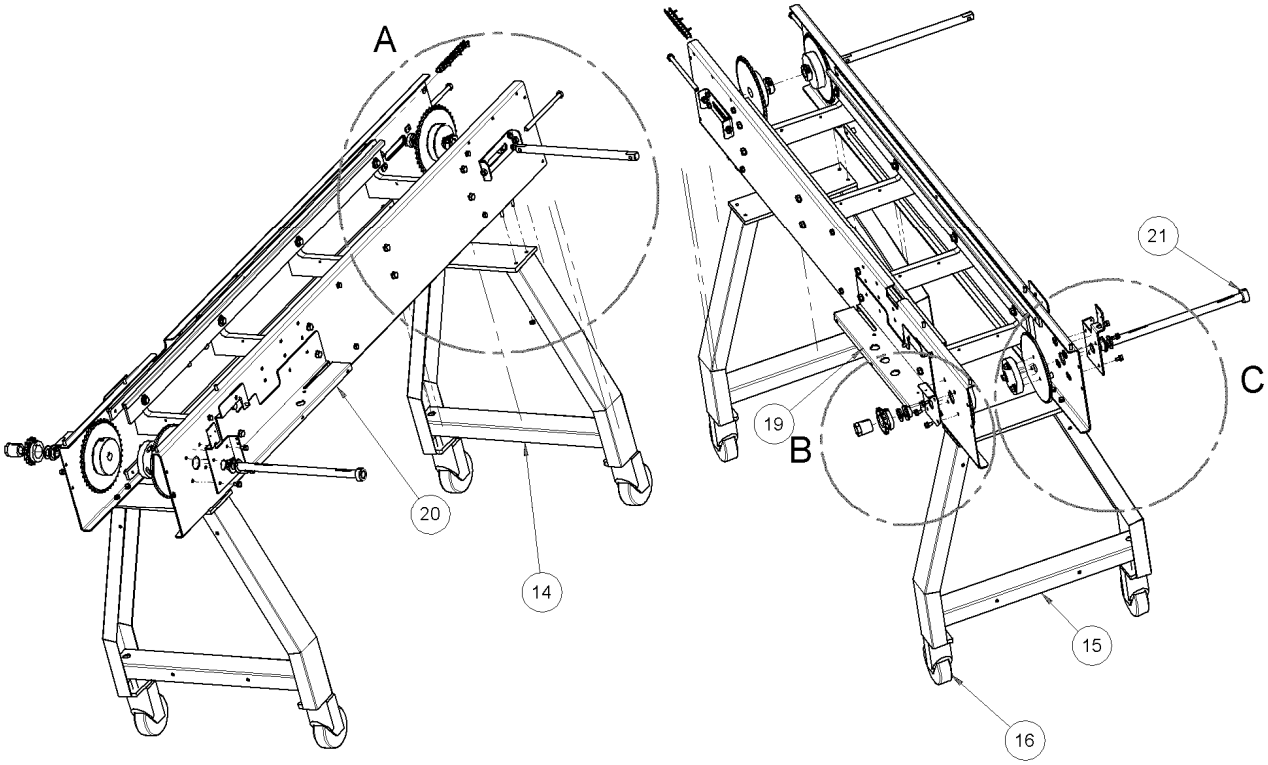
MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (BASE FRAME)

ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
1	FRAME FRONT	1908-0001	1
2	FRAME REAR	1908-0002	1
3	SPACER FRAME	1908-0003	4
4	SCREW HEX HD 3/8 -16 X 3/4 STST	5843-1052	24
5	WASHER 3/8 STST SPRING LOCK	5851-9359	24
6	TAKE UP – FRAME	1908-0054	2
7	SCREW HEX HD 1/4 – 20 X 1/2 STST	5843-1001	8
8	WASHER - 1/4 STST SPRING LOCK	5851-9357	8
9	SUPPORT CHAIN UPPER AND LOWER	1908-0007	4
10	STRIP CARRIER SUPPORT	1908-0024	2
11	WASHER – FLAT 3/8”	5851-9306	8
12	STRIP – WEAR 48.5” LONG	1908-0052	2
13	SPACER- CHAIN RAIL	1908-0010	12

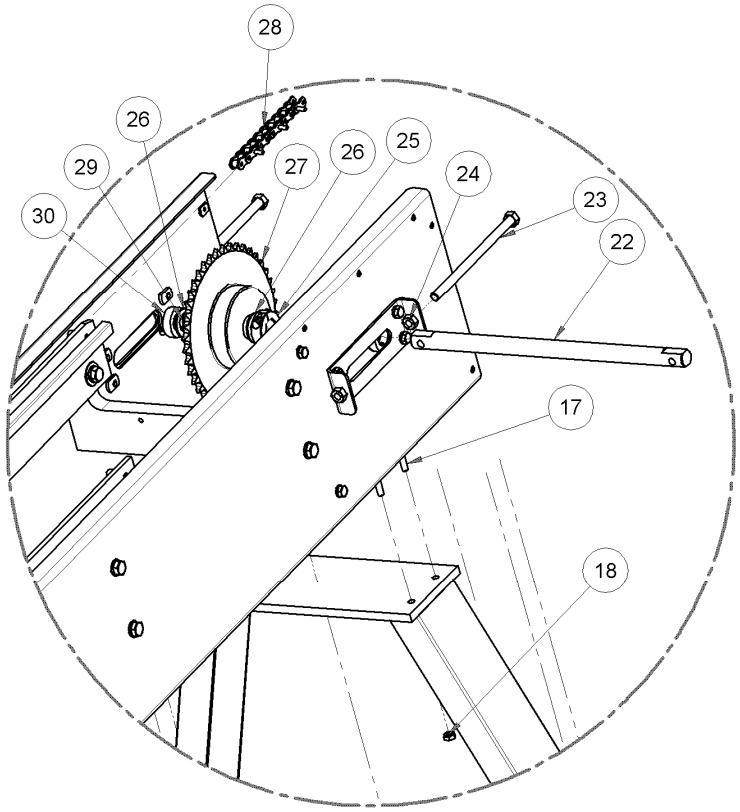
For Service Parts Call 800-253-3893

MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (FRAME)



ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
14	LEGS, SENIOR MEALS	1908-0027	1
15	LEGS, SENIOR MEALS W/ HOLES	1908-0301	1
16	CASTER- STEM, 4”	5902-2409	4
17	SCREW, HEX HD 1/4-20 X 1 STST	5843-1005	8
18	NUT, HEX FULL 1/4-20 STST	5832-0520	8
19	SHELF, FRONT	1908-0300-0001	1
20	SHELF, REAR	1908-0300-0002	1
21	COLLAR- SET 3/4” I.D. STST	5806-7057	1

MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (FRAME)



DETAIL A

ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
22	SHAFT, TAIL	1908-0006	1
23	SCREW, TAKE-UP 3/8-16 X 6 1/4 L.	1908-0005	2
24	NUT, HEX FULL 3/8-16 STST	5902-2409	2
25	COLLAR, SPLIT 3/4 BORE STST	5806-7115	2
26	BEARING, THRST 3/4 BORE	5254-0322	4
27	SPROCKET, 40B42, PLATED	5616-9349	2
28	CHAIN, MAIN (266 PITCHES)	5603-4928	2
29	BEARING, BRONZE SLEEVE	5254-0322	2

30	COLLAR, SET ¾ BORE	1908-0008	2

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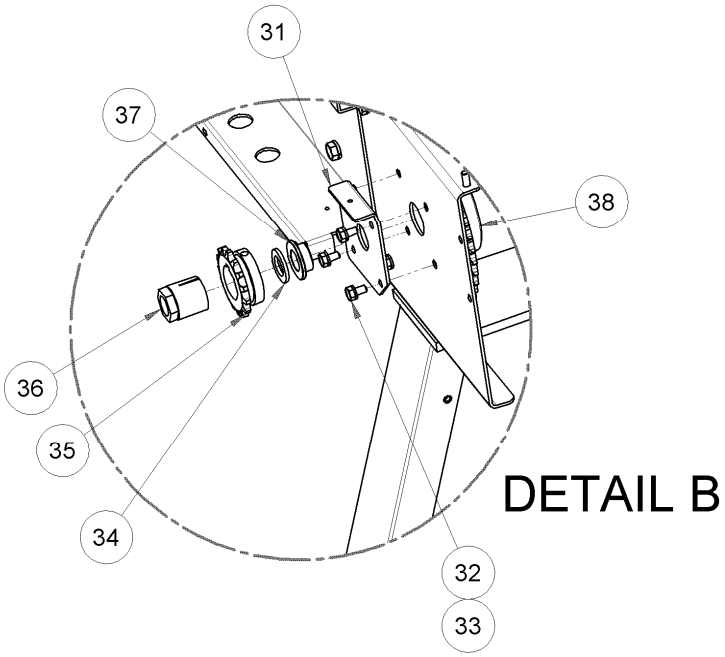
MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (FRAME)



ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
31	BRACKET, FRONT BUSHING	1908-0302	1
32	SCREW, HEX HD 1/4-20 X 1/2 STST	5843-1001	8
33	WASHER, LOCK 1/4 STST	5851-9357	8
34	WASHER, SPACER 3/4 I.D. STST	1908-0305	2
35	SPROCKET, 40B15 1 ¼ FB”	5616-9076	1
36	BUSHING, EXPANDING 3/4 I.D.	5902-0220	1
37	BEARING, BRONZE FLANGED	5254-3032	2
38	SPROCKET, 40B42 ¾ FB PLATED	5616-9347	1

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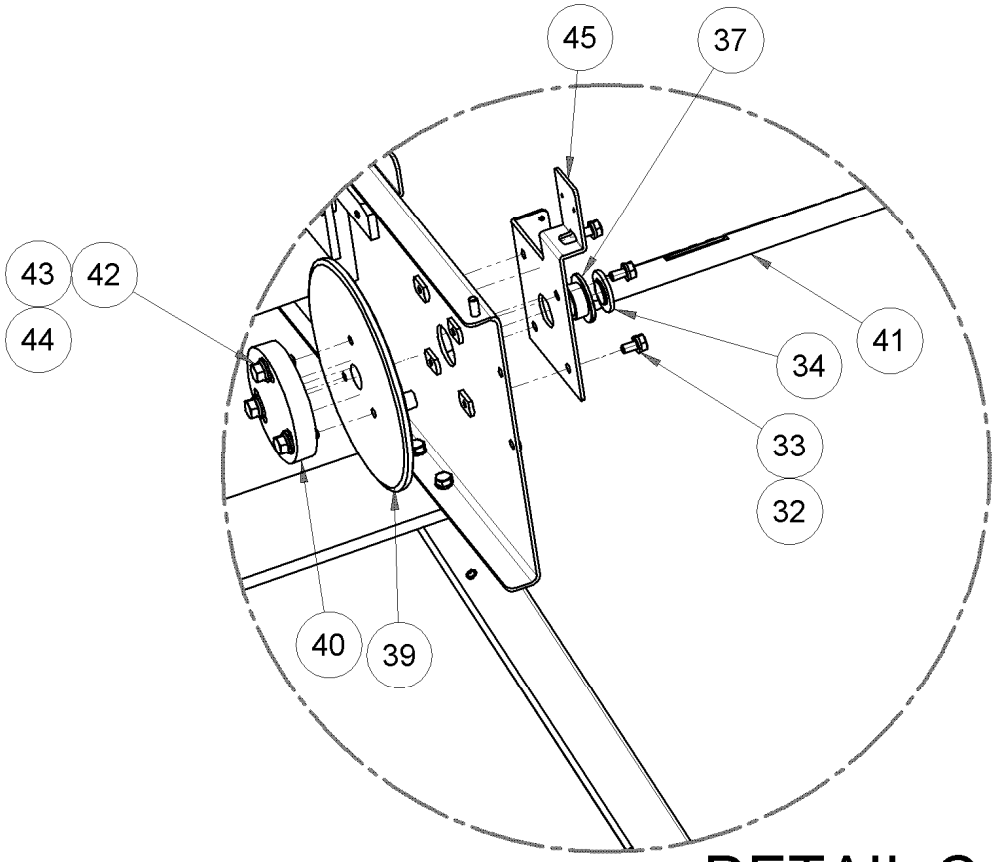
MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (FRAME)



DETAIL C

ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
39	SPROCKET, ADJUSTABLE 40A42	4615-4042-2431	1
40	RETAINER-HUB	1908-0053	1
41	SHAFT, CONVEYOR DRIVE	1908-0304	1
42	SCREW, HEX HD 5/16-18 X 1 STST	5843-1030	3
43	WASHER, LOCK 5/16 STST	5851-9358	3
44	WASHER, FLAT 5/16 STST	5851-9305	3
45	BRACKET, REAR BUSHING	1908-0303	1
46*	KEY 3/16 SQ. X 1 STST.	5824-2319	2

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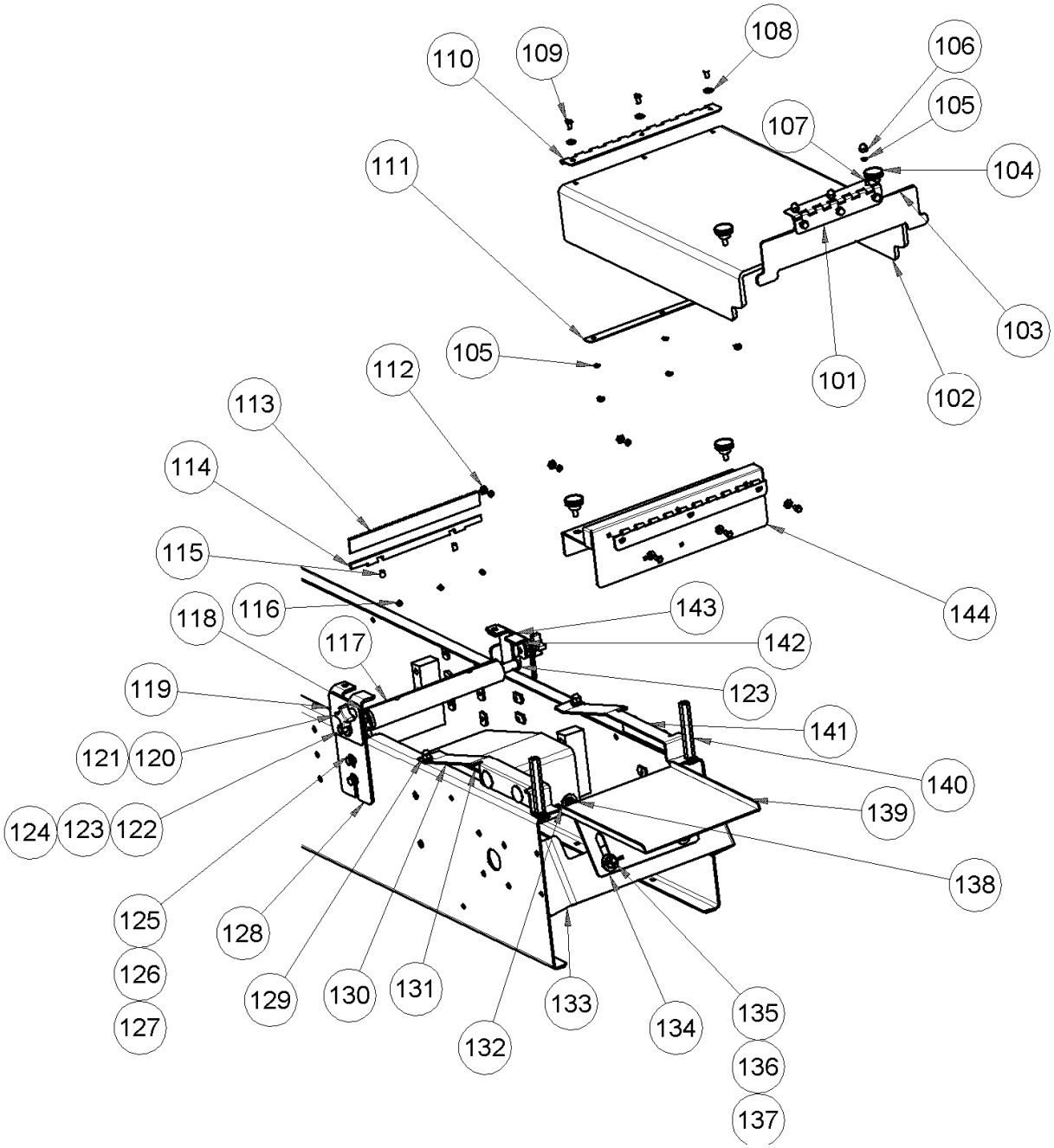
MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (CUTTER DISCHARGE ASSEMBLY)



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MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (CUTTER DISCHARGE ASSEMBLY)

ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
101	HINGE, DISCHARGE FLAP	1908-0306	1
102	COVER, DISCHARGE	5500-5341	1
103	COVER, DISCHARGE FLAP	5500-5342	1
104	KNOB, 1” DIA KNURLED 1/4-20	5911-7024	1
105	WASHER, #10 LOCK STST	5851-9355	12
106	NUT, ACORN #10-24	5832-0585	6
107	SCREW, TRUSS HD #10-24 X ½ STST	5843-5385	6
108	WASHER, FLAT #10 STST	5851-9302	6
109	SCREW, HEX HD #10-24 X ½ STST	1908-0060	6
110	HINGE (SHOWING HALF)	1908-0060	.5
111	STRIP, HINGE BACKER	1808-0058	1
112	NUT, HEX #10-24 STST	5832-0578	6
113	BLADE, CUTTER 9 X 7/8	7107-7200	1
114	STRIP, BACKER	1908-0031	1
115	SCREW, SOC-SET 1/4-20 X 1/4” STST	5843-2031	4
116	SCREW, SOC-SET 1/4-20 X 3/8” STST	5843-2033	2
117	HOLDER, BLADE 7” CUT-OFF	1908-0030	1
118	SPROCKET, 40B14 ½ BORE	4617-4014-1631	1
119	RETAINER, FRONT BUSHING	1908-0066-1001	1
120	T-KNOB, CAP 5/16 S.H.C.S	5911-7076	2
121	SCREW, S.H.C.S. 5/16-18 X ½ STST.	5843-1551	2

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MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (CUTTER DISCHARGE ASSEMBLY)

ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
122	BEARING SINT BRNZ FLNG	5254-3110	2
123	SHAFT- BLADE HOLDER	1908-0029	2
124	SPRING PIN	5835-6572	2
125	SCREW- HEX HEAD 1/4-20 X 5/8 STST	5843-1002	4
126	WASHER- FLAT 1/4 STST	5851-9304	12
127	WASHER- LOCK 1/4 STST	5851-9357	12
128	BRACKET- SIDE, CUTTER R.H.	1908-0065-0001	1
129	NUT- ACORN 1/4 - 20 STST	5832-0590	2
130	BASE- TRAY LIFT GUIDE R.H.	1908-0089	1
131	LIFT- SENIOR MEAL TRAY	1908-0088	1
132	RETAINER, LIFT RAMP INSIDE	1908-0084	2
133	BRACKET, DISCHARGE MNT.	1908-0085	1
134	SUPPORT- SHELF	69042	1
135	NUT- WING 3/8-16 STST	5832-0597	2
136	WASHER-FLAT 3/8 STST	5851-9306	2
137	WASHER- LOCK 3/8 STST	5851-9359	2
138	SCREW, HEX HD 1/4-20 X 3/4 STST	5843-1003	2
139	ADJUSTABLE GUIDE SHELF	69043	1
140	SPACER, COVER	1908-0058-001	2
141	BASE- TRAY LIFT GUIDE L.H.	1908-0090	1
142	BRACKET- SIDE, CUTTER L.H.	1908-0065-0002	1
143	RETAINER, REAR BUSHING	1908-0066-1002	1
144	COVER- CUTTER	1908-0032-001	1
145*	NUT 1/4-20 WING STST	5832-0595	2

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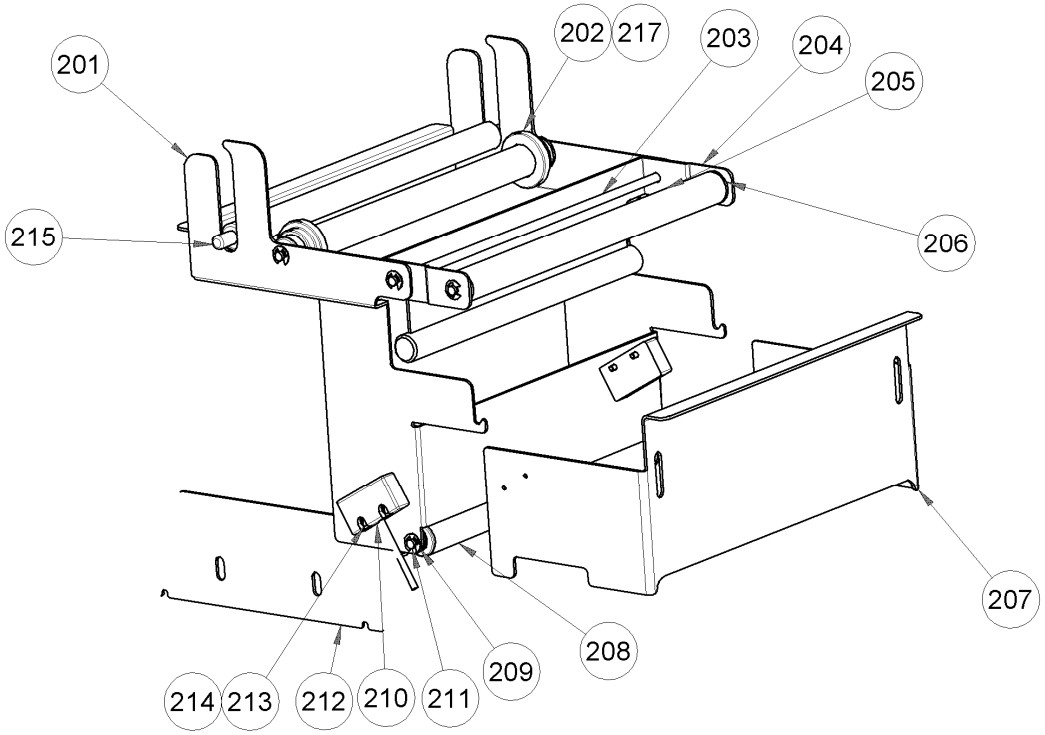
MECHANICAL REPLACEMENT PARTS LIST

EXPLODED VIEW (TOP ASSEMBLY, GUARD, ROLL HOLDER)



ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
201	GUARD/ ROLL HOLDER WELDMENT	1908-0308	1
202	ROLLER FILM GUIDE	1908-0041	2
203	ROD-FILM DISPENSER 11 1/4 L	1908-0043	3
204	BRACKET FILM TAKEUP	1908-0163	1
205	TUBE, ALUMINUM 7/8 O.D. X 10 1/2 L	4639-1414-1114	2
206	BEARING, ROLL END	5252-3002	6
207	GUARD, INFEED GATE	1908-0309	1
208	TUBE, ALUMINUM 7/8 O.D. X 9 1/4 L	4639-1414-1114	1
209	RING, RETAINING 1/4	5840-1273	8
210	SAFETY SWITCH (W/ CONNECTOR)	1908-0416	1
211	ROD-FILM DISPENSER 10 1/4 L	1908-0040	1
212	BRACKET, PLATEN GUARD (REAR)	1908-0307-0001	1
213	SCREW, RND HD #6-32 X 1/2 STST	5843-5212	4

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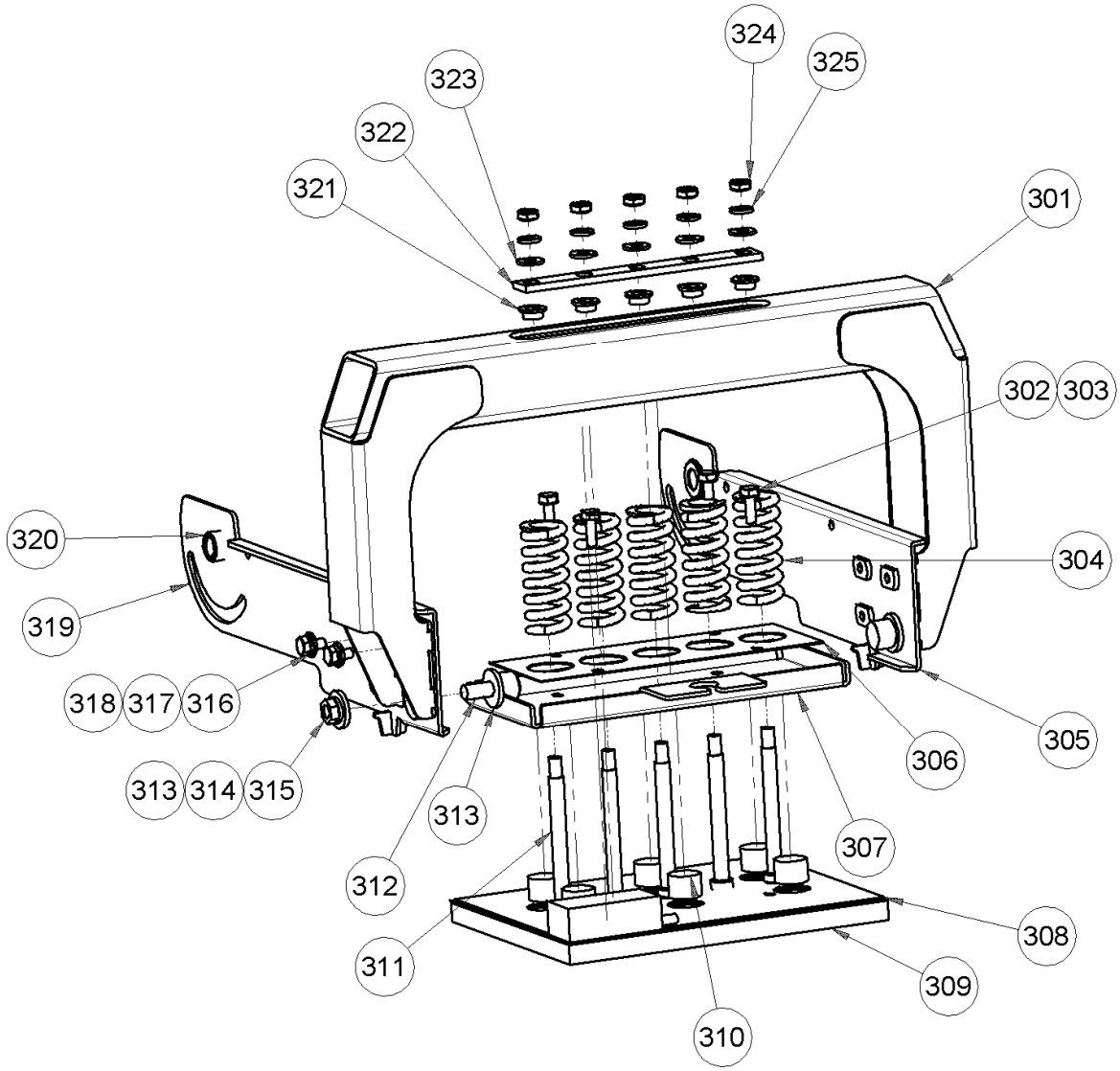
ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
214	WASHER, LOCK #6 STST	5851-9353	4
215	ROLLER- FILM WEIGHT	1908-0310	1
216*	BRACKET, PLATEN GUARD (FRONT)	1908-0307-0001	1
217*	“O” RING 13/16 I.D. X 1 1/16 O.D.	6909-3211	2

MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (ARCH-PLATEN ASSEMBLY)



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MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (ARCH-PLATEN ASSEMBLY)

ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
301	ARCH WELDMENT ASSY	1908-0311	1
302	SCREW, HEX HD 1/4-20 X 3/4 STST	5843-1003	4
303	WASHER, LOCK INT. TOOTH ¼ STST	5851-9395	1
304	SPRING, COMPRESSION	7014-4400	5
305	ARM, FRONT PIVOT	1908-0317	1
306	PLATE, PLATEN SPRING	1908-0313	1
307	PAN, PLATEN SPRING	1908-0312	1
308	PLATE, HEATER COVER	1908-0316	1
309	HEATER PLATEN ASSY	1908-25607	1
310	CYLINDER, HEATER STANDOFF	1908-0315	6
311	SCREW, SHLDR 3/8 X 3 1/2 STST	5842-8999	5
312	BEARING, CAM FOLLOWER 3/4 DIA	5251-0021	2
313	WASHER, SPACER, 3/8 I.D	1908-0319	6
314	WASHER, LOCK 3/8 STST	5851-9359	2
315	NUT – HEX JAM 3/8-24 STST	5832-0552	2
316	SCREW, HEX HD 1/4-20 X 1/2 STST	5843-1001	6
317	WASHER, LOCK 1/4 STST	5851-9357	6
318	WASHER, FLAT 1/4 STST	5851-9305	6
319	ARM, REAR PIVOT	1908-0318	1
320	BEARING, SINT. BRNZ. FL. 1/2 I.D.	5254-3110	2
321	BEARING, SINT. BRNZ. FL. 3/8 I.D.	5254-3085	5
322	BAR, BOLT SPACER	1908-0314	1
323	WASHER-FLAT 5/16” STST	5851-9305	5
324	NUT, HEX 5/16-18 STST	5832-0521	5
325	WASHER, LOCK 5/16 STST	5851-9358	5

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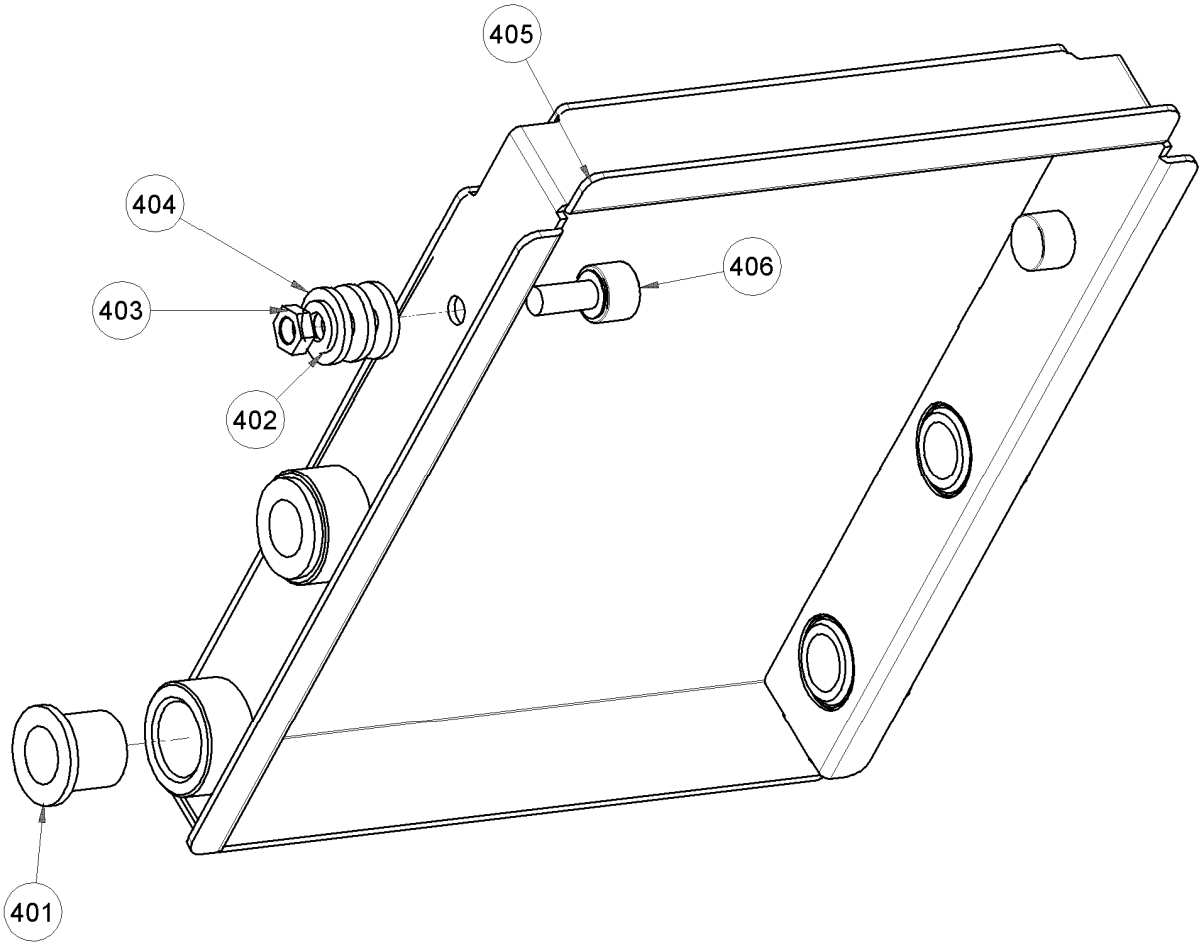
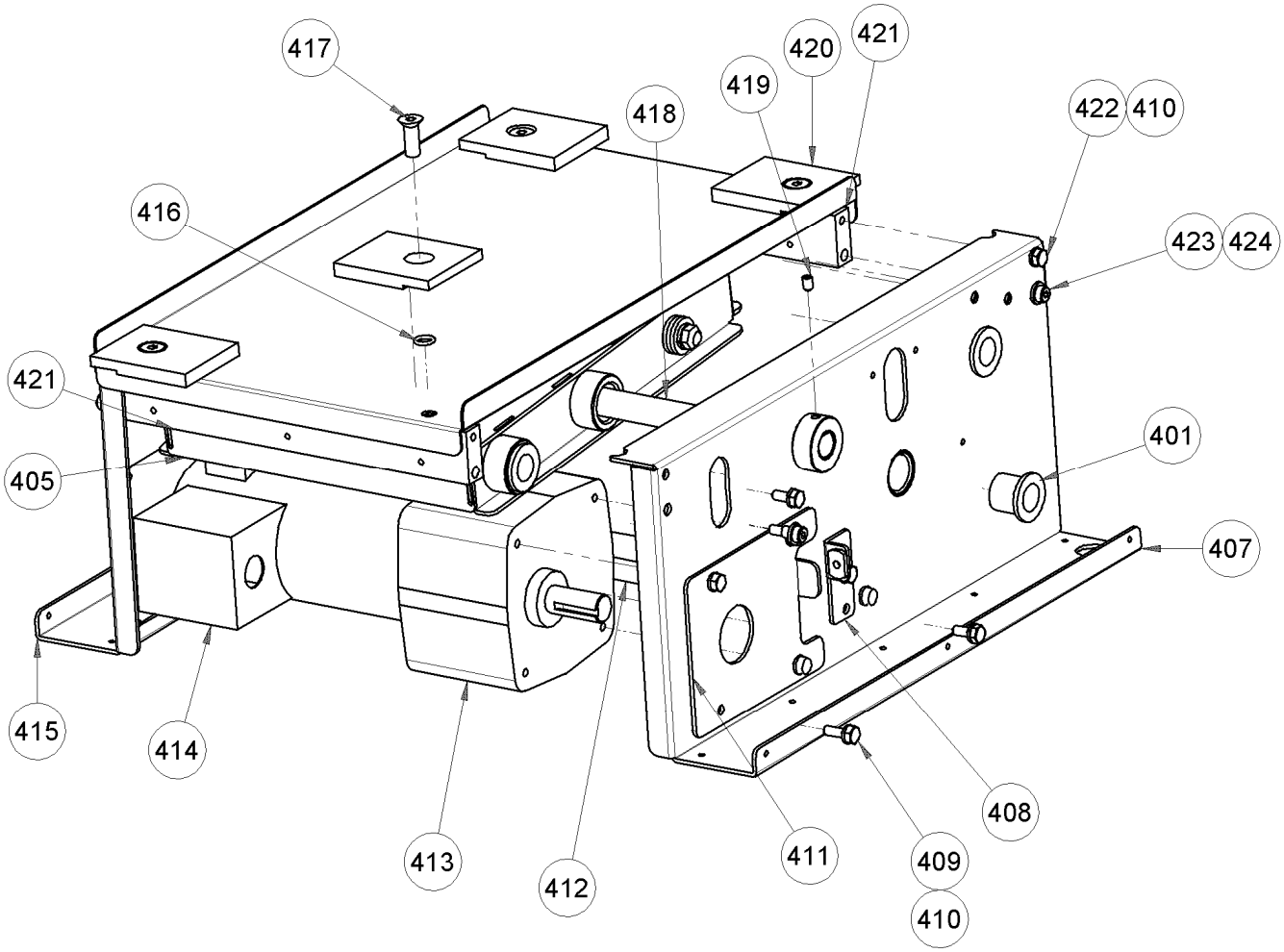
MECHANICAL REPLACEMENT PARTS LIST

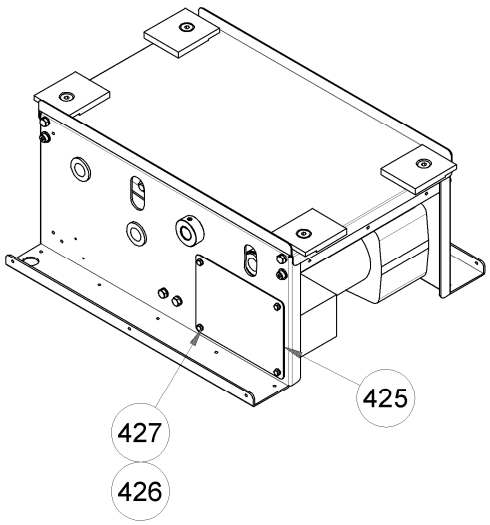
EXPLODED VIEW (DRIVE BOX ASSEMBLY (ROCKER))



ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
401	BEARING, SINT BRONZE 3/4 I.D.	5254-3139	8
402	WASHER, LOCK 3/8 STST	5851-9359	2
403	NUT – HEX JAM 3/8-24 STST	5832-0552	2
404	WASHER, SPACER, 3/8 I.D	1908-0319	6
405	WELDMENT, ROCKER FRAME	1908-0326	1
406	BEARING, CAM FOLLOWER 3/4 DIA	5251-0021	2

MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (DRIVE BOX ASSEMBLY (BASE))





MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (DRIVE BOX ASSEMBLY (BASE))

ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
407	WELDMENT, FRONT PANEL	1908-0320-0001	1
408	BRACKET, CHAIN ADJUSTER	1908-0323	1
409	SCREW, HEX HD 1/4 -28 X 3/4 STST	5843-1253	4
410	WASHER, LOCK 1/4 STST	5851-9357	13
411	PLATE, MOTOR MOUNT	1908-0321	1
412	BAR- BOTTOM TIE	1908-0322	1
413	GEARMOTOR, DC	6310-0203	1
414	BOX, GEARMOTOR CONDUIT	6310-4000	1
415	WELDMENT, REAR PANEL	1908-0320-0002	1
416	“O” RING, 3/8 I.D.	6909-3110	4
417	SCREW, FLAT SOC HD 3/8-16 X 1 STST	5843-2745	4
418	SHAFT, ROCKER	1908-0327	1
419	SCREW, SOC SET 1/4-20 X 3/8	5843-2033	2
420	BLOCK, MOUNTING CLAMP	1908-0329	4
421	BAR- TOP TIE	1908-0324	2
422	SCREW, HEX HD 1/4-20 X 5/8	5843-1002	9
423	SCREW – SHOULDER 5/16 X 3/8	5842-8958	4
424	WASHER-LOCK 5/15 STST	5851-9358	4
425	PLATE, MOTOR COVER	1908-0328	1
426	SCREW, HEX HD #10-24 X 3/8 STST	5843-1231	4
427	WASHER, LOCK #10 STST	5851-9355	4
428	TOP PANEL	1908-0325	1

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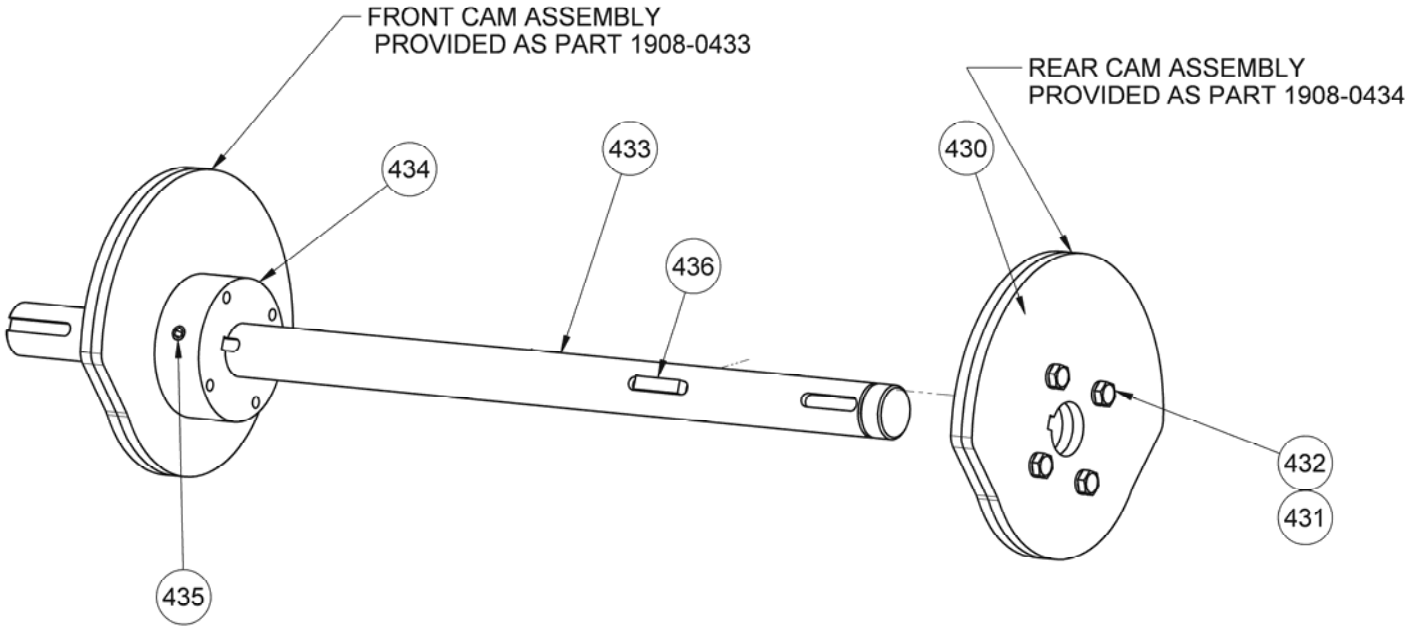
MECHANICAL REPLACEMENT PARTS LIST

EXPLODED VIEW (DRIVE BOX ASSEMBLY (PLATEN CAM))



REV 1/6/12

ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
430	PLATE, PLATEN CAM	1908-0341	4
431	SCREW, HEX HD #10-24 X 3/4 STST	5843-1234	8
432	WASHER, LOCK #10 STST	5851-9355	16
433	SHAFT, DRIVE INPUT	1908-0336	1
434	HUB, PLATEN CAM	1908-0340	2
435	SCREW, SOCKET SET 1/4-20 X 3/8	5842-6133	7
436	KEY, 3/16 SQ. X 3/4	5824-2318	7

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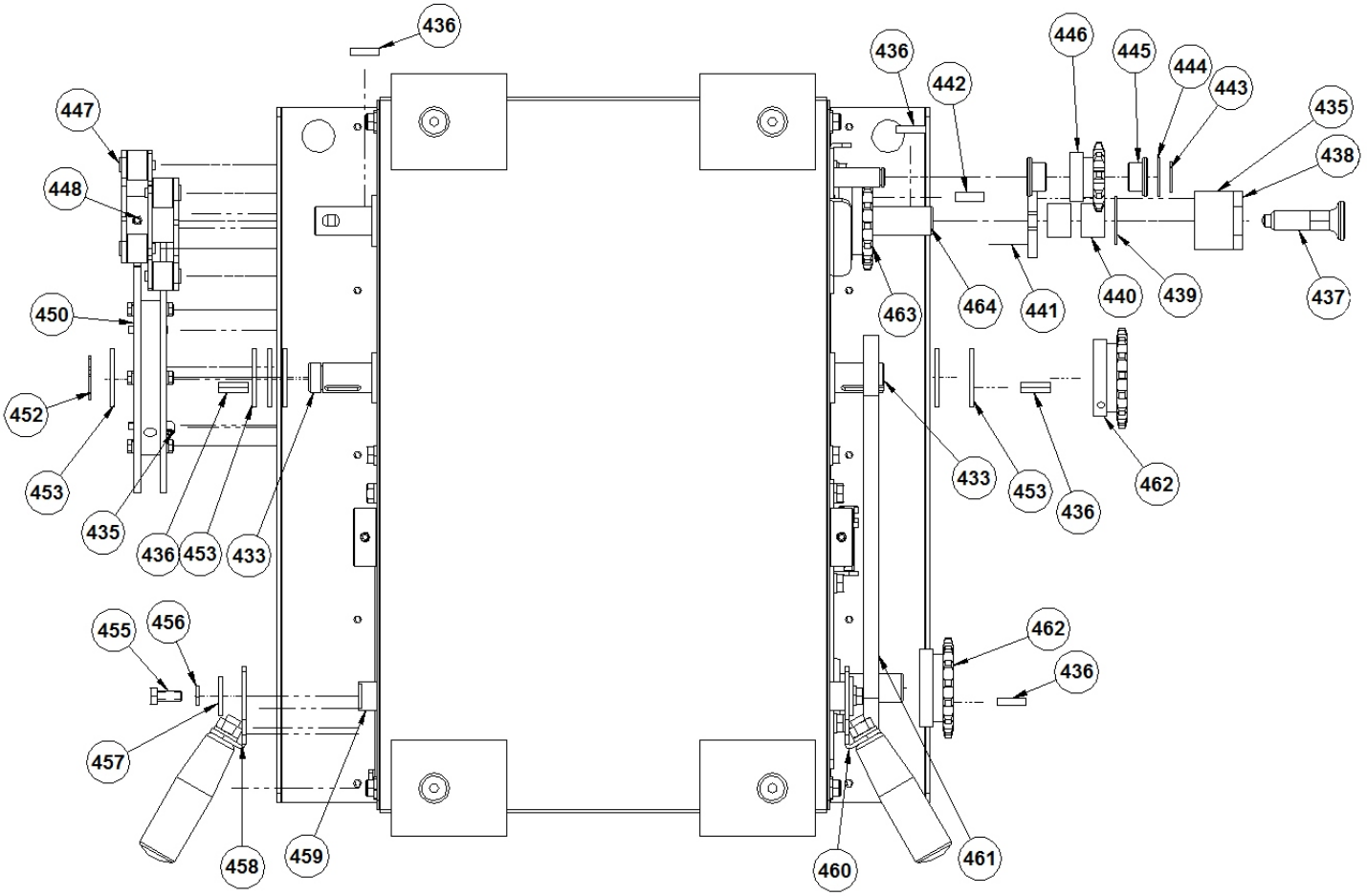
MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (DRIVE BOX ASSEMBLY (EXTERIOR))



ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
437	PIN, LOCKING MANUAL PULL	5835-7930	1
438	CONVEYOR DRIVE LOCK BLOCK	1908-0335	1
439	BEARING, SINT. BRNZ THRUST 3/4 I.D.	5254-3514	1
440	BEARING, SINT. BRNZ SLEEVE 3/4 I.D.	5254-0300	2
441	HUB, CONVEYOR DRIVE	1908-0334	1
442	KEY, 1/4 SQ. X 3/4	5824-2324	1
443	RING, RETAINING E-CLIP STST 1/2 I.D.	5840-2839	1
444	WASHER-SPACER 1/2 I.D. X 16 GA.	1908-0331	1
445	BEARING, SINT. BRNZ FL 1/2 I.D.	5254-3110	2

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MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (DRIVE BOX ASSEMBLY (EXTERIOR))

ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
446	SPROCKET, #40 10 TOOTH 3/4 BORE	5616-9023	1
447	INDEXER ROLLER ASSEMBLY	1908-0333	1
448	SCREW, SOCKET SET 1/4-20 X 1/4	5842-6131	2
450	INDEXER CAM ASSEMBLY	1908-0359	1
452	RING, RETAINING E-CLIP STST 3/4 I.D.	5840-2841	1
453	WASHER-SPACER KEYED 3/4 I.D.	1908-0339	6
455	SCREW-HEX HD, 1/4-20 X 5/8 STST	5843-1002	2
456	WASHER, LOCK 1/4 STST	5851-9357	3
457	WASHER, PULL DOWN	1908-0344	2
458	LINK, PLATEN PULL DOWN, REAR	1908-0343-0002	1
459	SHAFT, PULL DOWN	1908-0342	1
460	LINK, PLATEN PULL DOWN, FRONT	1908-0343-0001	1
461	CHAIN, #40 ROLLER	5603-4003	2 FT.
462	SPROCKET, #40 15 TOOTH 3/4 BORE	5616-9073	2
463	SPROCKET, #40 15 TOOTH 1 1/4 BORE	5616-9076	1
464	SHAFT, CONVEYOR DRIVE OUTPUT	1908-0332	1

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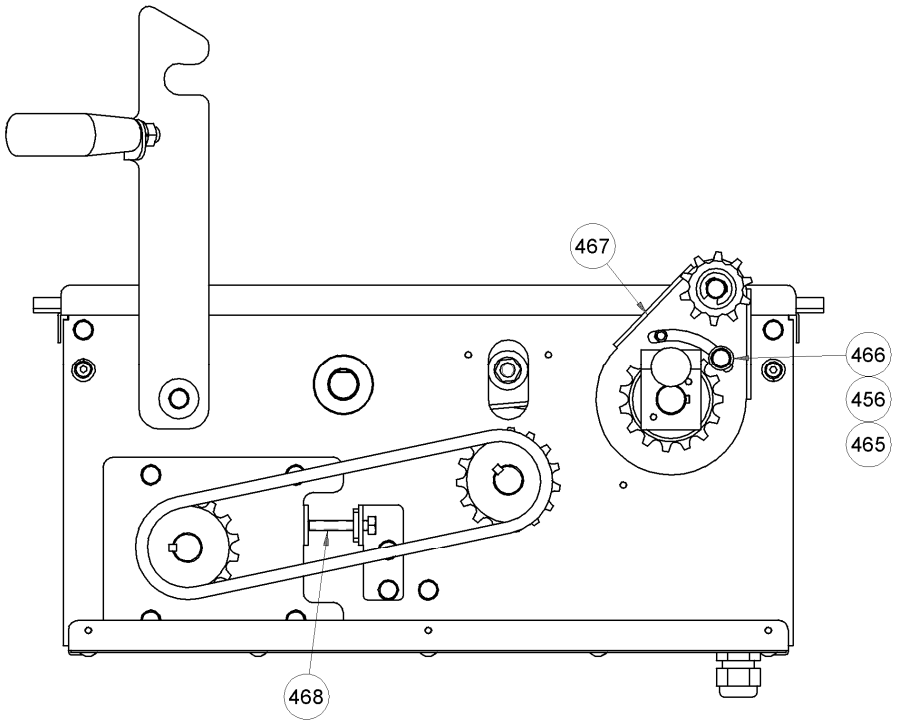
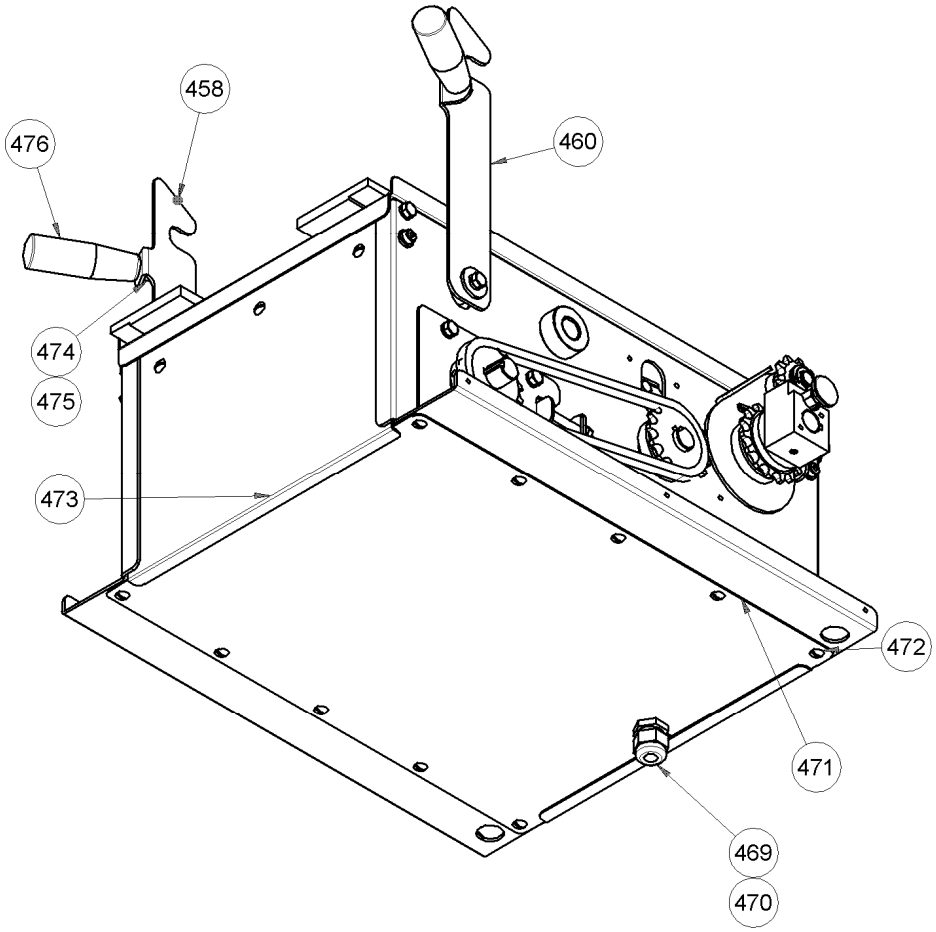
MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (DRIVE BOX ASSEMBLY (EXTERIOR))



ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
465	SCREW, HEX HD 1/4-20 X 1/2 STST	5843-1001	1
466	WASHER-FLAT 1/4 STST	5851-9304	1
467	WELDMENT, IDLER BRACKET	1908-0330	1
468	SCREW, HEX HD 1/4-20 X 1 1/2 STST	5843-1007	1
469	STRAIN RELIEF, 1/2 NPT	5765-1082	1
470	NUT, 1/2 NPT LOCK	5766-7750	1
471	PANEL, BOTTOM	1908-0345	1
472	SCREW, TRUSS HD #10-24 X 3/8 STST	5843-5384	16
473	PANEL, END	1908-0347	2
474	NUT, HEX 3/8-16 STST	5832-0522	2
475	WASHER, LOCK 3/8 STST	5851-9359	2
476	HANDLE, 1” DIA X 3” 3/8-16 STUD	5908-5058	2

MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (DRIVE BOX ASSEMBLY (EXTERIOR))



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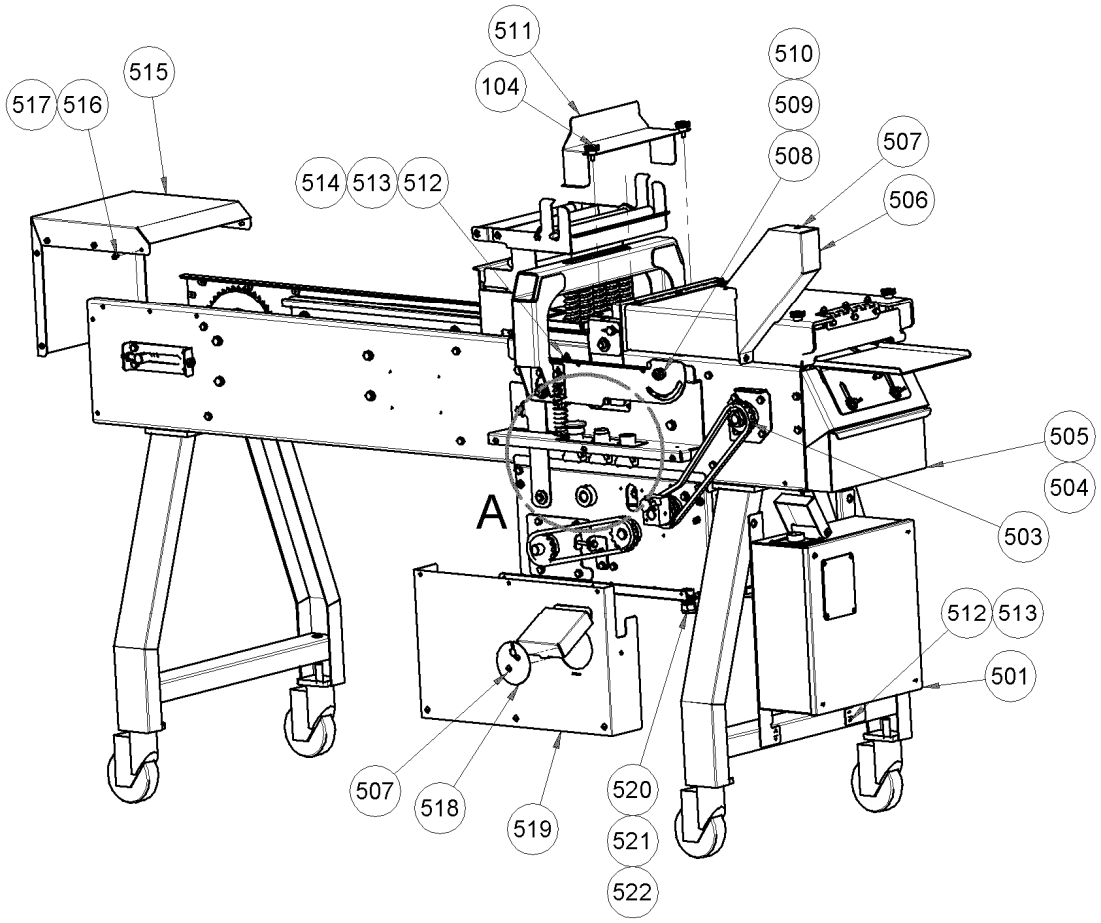
MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (MAIN ASSEMBLY)



ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
501	ELECTRICAL BOX ASSEMBLY	1908-25611	1
503	CHAIN, #40 ROLLER	5603-4003	3 FT.
504	PAN, INFEED BOTTOM	1908-0411	1
505	PAN, OUTFEED BOTTOM	1908-0412	1
506	GUARD, FRONT CHAIN	1908-0407	1
507	SCREW, TRUSS HD #10-24 X 3/8 STST	5843-5384	17
508	SCREW, SHOULDER ½ DIA X ½ L STST	5842-8996	2
509	WASHER-LOCK, 3/8 STST	5851-9359	2
510	NUT, HEX 3/8-16 STST	5832-0522	2

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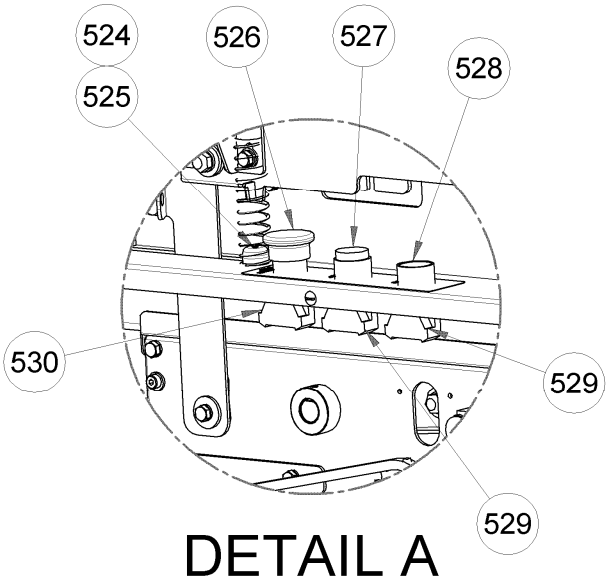
MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (MAIN ASSEMBLY)

ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
511	COVER, PLATEN BACK	1908- 0410	1
512	SCREW, HEX HD 1/4-20 X 1/2 STST	5843-1001	8
513	WASHER, LOCK 1/4 STST	5851-9357	8
514	WASHER, FLAT 1/4 STST	5851-9304	4
515	GUARD, INFEED	1908-0021	1
516	SCREW, HEX HD #10-24 X 3/8 STST	5843-1231	10
517	WASHER, LOCK #10 STST	5851-9355	10
518	SHEILD, SHAFT LOCK	1908-0405	1
519	WELDMENT, FRONT COVER	1908-0406	1
520	STRAIN RELIEF, 1/2 NPT	5765-1082	2
521	NUT, 1/2 NPT LOCK	5766-7750	2
522	CONTROL CABLE ASSEMBLY, FRONT	1908-0402	1



DETAIL A

524	BUTTON, SPRING MOUNT	1908-0404	2
525	SPRING, COMPRESSION	7015-5100	2
526	PUSH BUTTON, MUSHROOM RED	5708-7920	2

3

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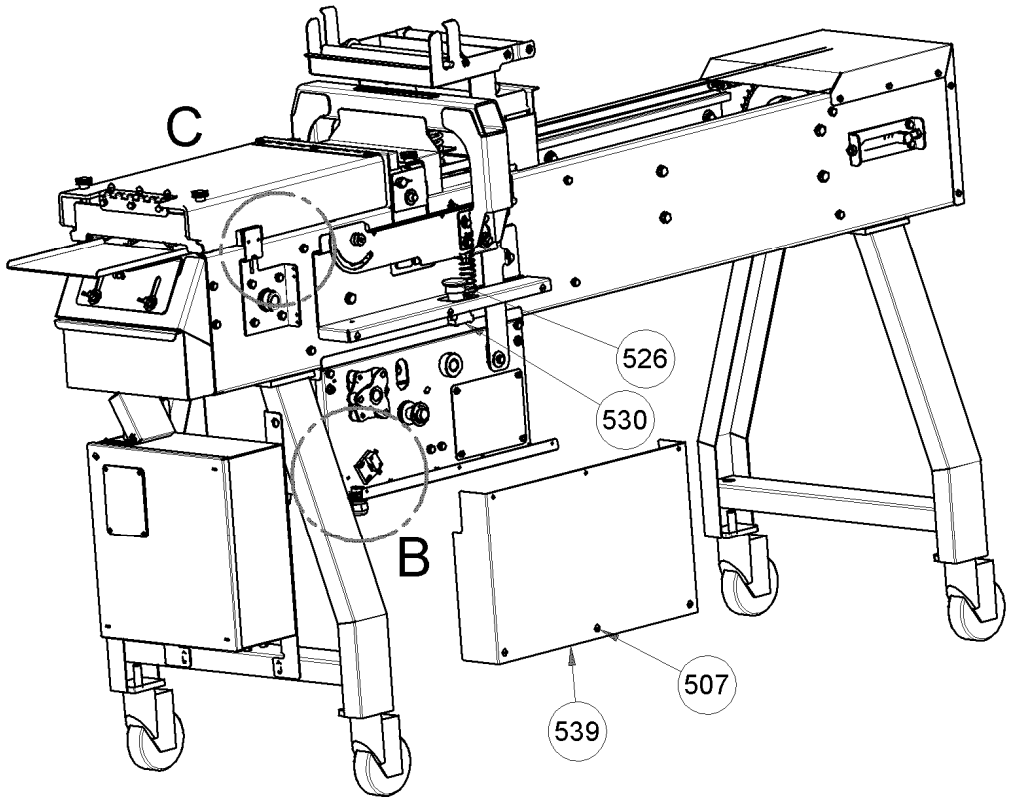
MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (MAIN ASSEMBLY)

ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
527	PUSH BUTTON, EXTENDED RED	5708-7908	1
528	PUSH BUTTON, FLUSH GREEN	5708-7900	1
529	CONTACT BLOCK, NO	5708-7930	2
530	CONTACT BLOCK, NC	5708-7931	2



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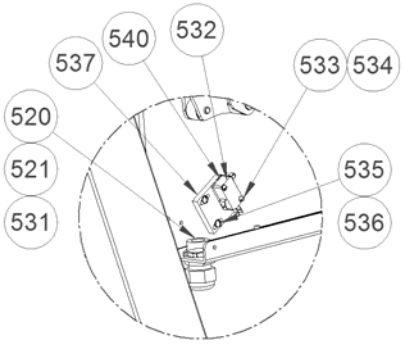
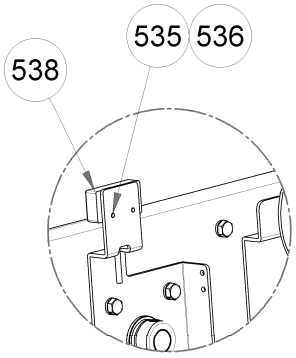
MECHANICAL REPLACEMENT PARTS LIST
EXPLODED VIEW (MAIN ASSEMBLY)



DETAIL B

ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
531	CONTROL CABLE ASSEMBLY, REAR	1908-0403	1
532	SWITCH, LIMIT W/ ROLLER	5757-8002	1
533	SCREW, RND HEAD #4-40 X 3/4	5843-5193	2
534	WASHER, LOCK #4 STST	5851-9352	2
535	SCREW, RND HEAD #6-32 X 1/2 STST	5843-5212	2
536	WASHER, LOCK SHKPRF #6 STST	5851-9219	2
537	BLOCK, LIMIT SWITCH SPACER	1908-0408	1



DETAIL C

538	SAFETY SWITCH W/ CONNECTOR	1908-0416	1
539	REAR COVER	1908-0409	1
540	SHIM, LIMIT SWITCH MNT	1908-0417	1

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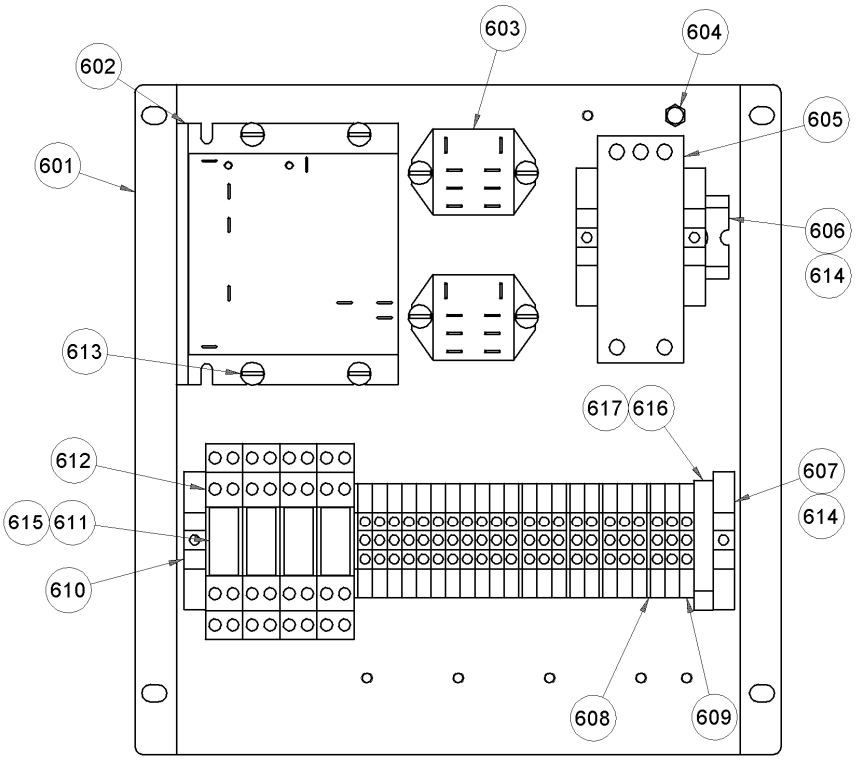
ELECTRICAL BOX REPLACEMENT PARTS LIST

NOTE: SEE THE MECHANICAL LIST FOR ELECTRICAL PARTS NOT ASSOCIATED WITH THE ELECTRICAL BOX (PUSH BUTTONS, CABLES, LIMIT SWITCHES, MOTOR, ETC.)

BACK PLANE ASSEMBLY VIEW (INTERNAL):

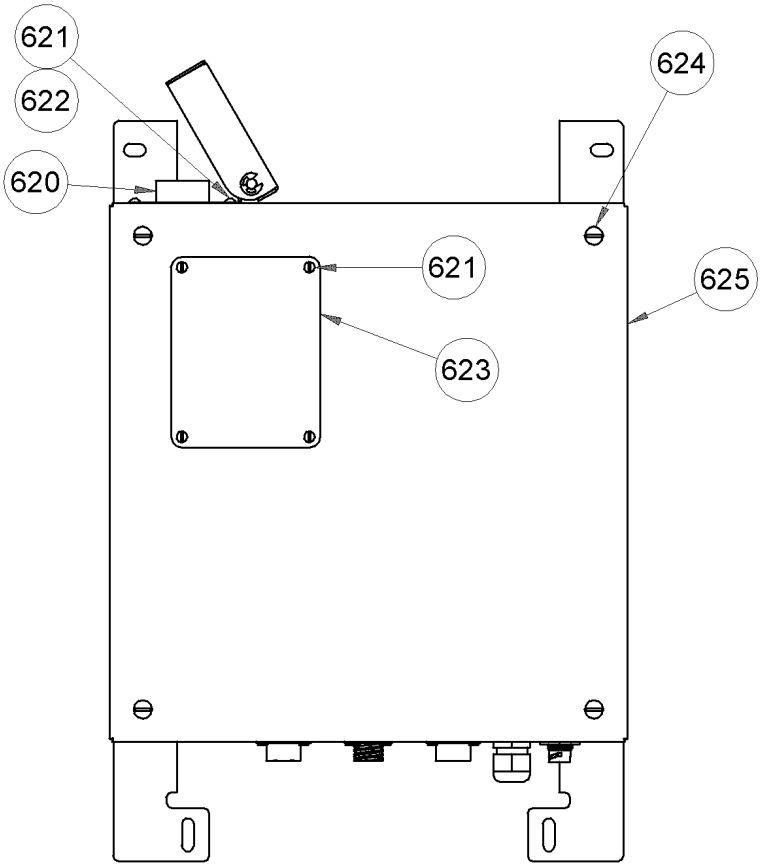


ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
601	PLATE, ELECTRICAL BACK PLANE	1908-0348	1
602	DC DRIVE AND POTENTIOMETER ASSY	1908-0351	1
603	RELAY, 30A 2 POLE 120/250 VAC	5749-8034	2
604	SCREW, #10-24 GROUND	5841-1052	7
605	POWER SUPPLY, 24VDC 60W	5746-5305	1
606	RAIL, 2.5” DIN	1908-0350	1
607	RAIL, 9” DIN	1908-0349	1
608	BARRIER-END TERM. BLOCK	5770-7474	5
609	BLOCK, TERMINAL DIN MNT.	5770-7472	23
610	ANCHOR-END TERM. BLOCK	5770-7475	4

ELECTRICAL BOX REPLACEMENT PARTS LIST

ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
611	RELAY, DPDT 8A 24VDC	5749-5674	4
612	SOCKET- 8 PIN	5770-2832	4
613	SCREW, #8-32 X 3/8 STST	5843-5372	8
614	SCREW, #10-24 X 3/8 STST	5843-5384	8
615	CLIP, RELAY HOLD-DOWN	5749-5697	4

BOX FRONT VIEW:



620	KNOB KIT	6309-6035	1
621	SCREW - RND HD #6-32 X 1/4 STST	5843-5210	8
622	WASHER, #6 LOCK STST	5851-9353	4
623	WINDOW, CONTROL BOX	5500-5343	1
624	SCREW, TRUSS HD #10-24 X 1/2 STST	5843-5385	4
625	COVER, ELECTRICAL BOX	1908-0415	1

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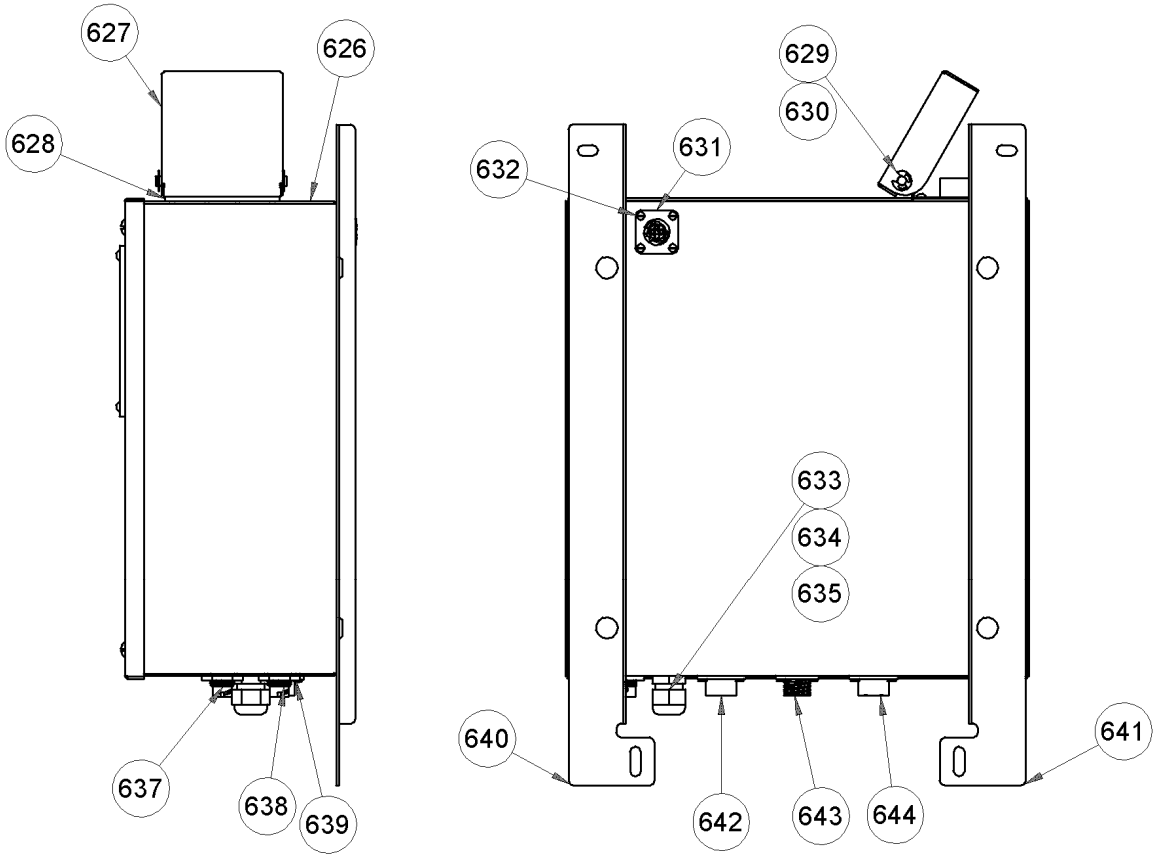
ELECTRICAL BOX REPLACEMENT PARTS LIST
BOX SIDE AND BACK VIEW:



ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
626	BOX, ELECTRICAL	1908-0413	1
627	COVER, POTENTIOMETER GUARD	1908-0357	1
628	BASE, POTIOMETER GUARD	1908-0356	1
629	ROD, POTENTIOMETER GUARD	1908-0358	1
630	RING, RETAINING 1/4” STST	5840-1273	2
631	RECEPTACLE, HEATER	1908-0399	1
632	SCREW, PAN HD 4-40 X 3/16 STST	5843-5520	16
633	ENTRY/ SW. MOD. 1 POLE W/ LIGHT	5746-7910	1
634	SCREW, F.H. #4-40 X 3/8 STST	5843-5022	2

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ITEM NO	PART DESCRIPTION	PART NUMBER	QUANITY
635	FUSE DRAWER W/ SHORTING BAR	5746-7950	1
636	FUSE, 10A	5725-9974	1
637	RECEPTACLE, SAFETY INTERLOCK 1	1908-0395	1
638	RECEPTACLE, SAFETY INTERLOCK 2	1908-0396	1
639	NUT, BRASS JAMB 5/8-24 UNEF	5832-0619	2
640	BRACKET, E-BOX MNT R.H.	1908-0414-0001	1
641	BRACKET, E-BOX MNT L.H.	1908-0414-0002	1
642	RECEPTACLE, R.H. SIDE	1908-0398	1
643	RECEPTACLE, MOTOR	1908-0401	1
644	RECEPTACLE, L.H. SIDE	1908-0400	1

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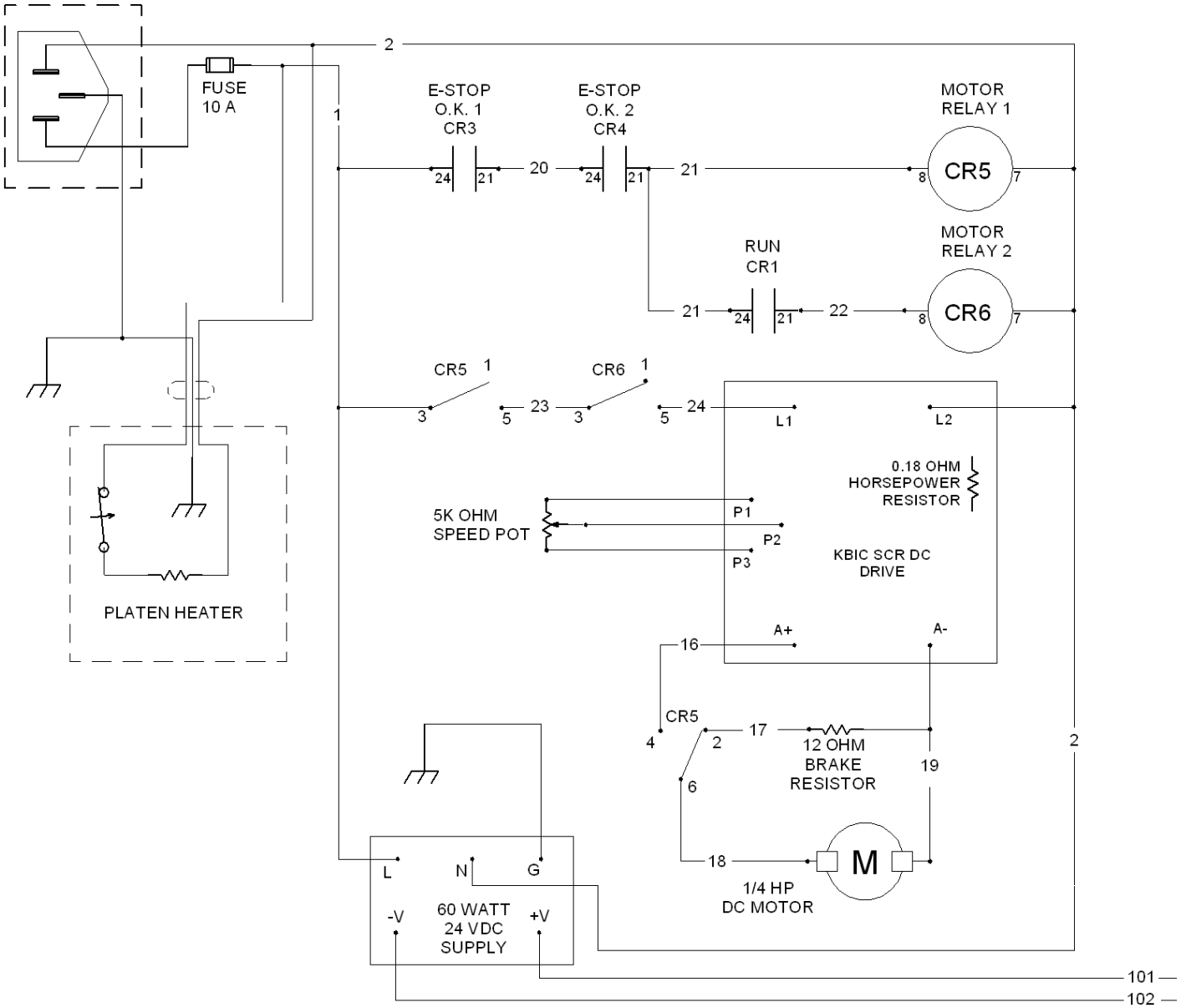
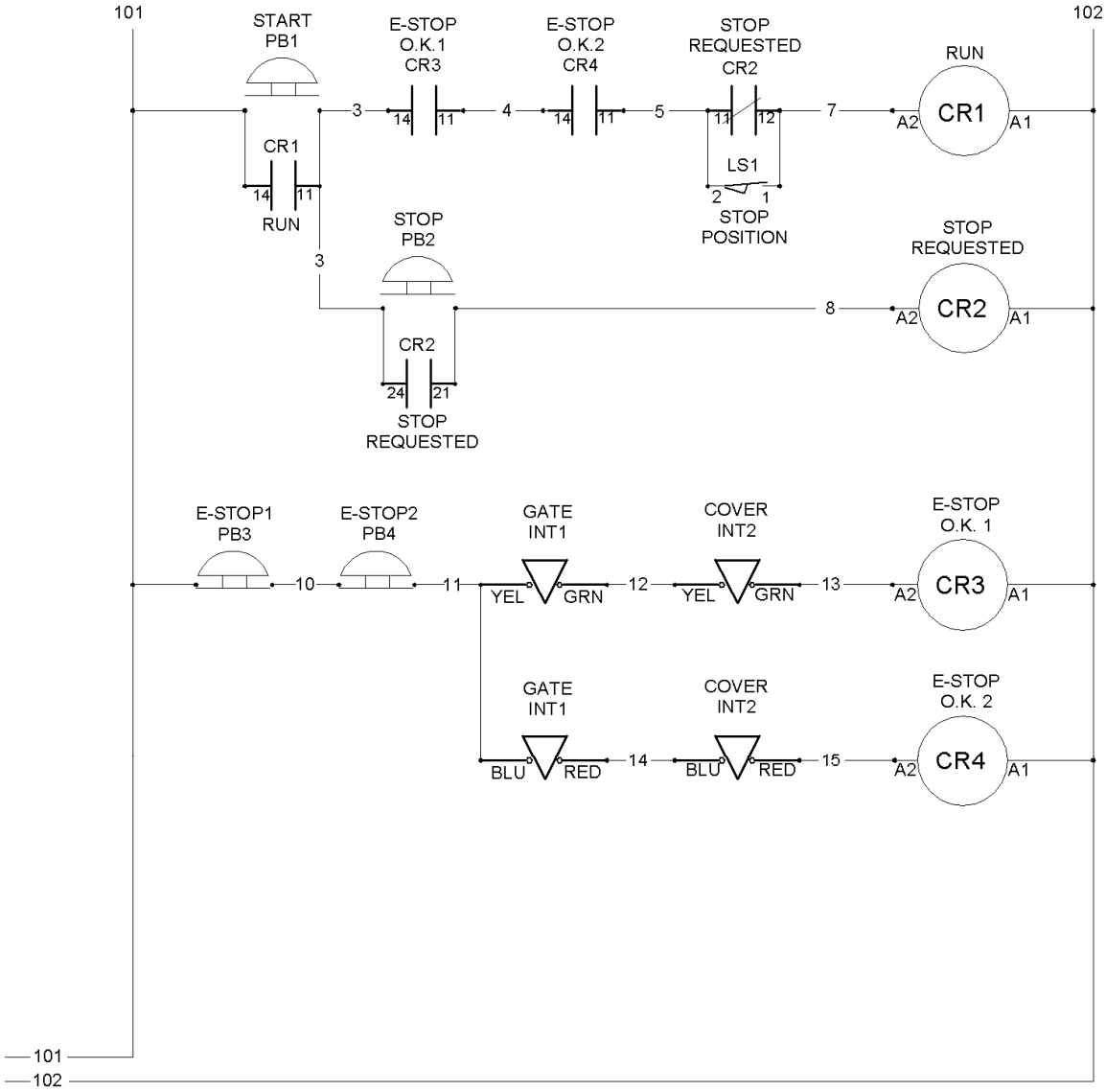
120 VAC, 60 HZ.
SINGLE PHASE




101
102
START PB1
E-STOP O.K.1 CR3
E-STOP O.K.2 CR4
STOP REQUESTED CR2
RUN
CR1
LS1
STOP POSITION
CR1 RUN
STOP PB2
CR2 STOP REQUESTED
STOP REQUESTED
CR2
E-STOP1 PB3
E-STOP2 PB4
GATE INT1
COVER INT2
E-STOP O.K. 1
CR3
GATE INT1
COVER INT2
E-STOP O.K. 2
CR4
YEL GRN
BLU RED
A1 A2
14 11
11 12
2 1
24 21

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WARRANTY

PARTS
Oliver Packaging & Equipment Company warrants that if any part of the equipment (other than a part not manufactured by Oliver Packaging & Equipment) proves to be defective (as defined below) within one year after shipment, and if Buyer returns the defective part to Oliver Packaging & Equipment within one year, Freight Prepaid to Oliver Packaging & Equipment's plant in Grand Rapids, MI, then Oliver Packaging & Equipment, shall, at Oliver Packaging & Equipment's option, either repair or replace the defective part, at Oliver Packaging & Equipment's expense.

LABOR
Oliver Packaging & Equipment further warrants that equipment properly installed in accordance with our special instructions, which proves to be defective in material or workmanship under normal use within one (1) year from installation or one (1) year and three (3) months from actual shipment date, whichever date comes first, will be repaired by Oliver Packaging & Equipment or an Oliver Packaging & Equipment Authorized Service Dealer, in accordance with Oliver Packaging & Equipment's published Service Schedule.

For purposes of this warranty, a defective part or defective equipment is a part or equipment which is found by Oliver Packaging & Equipment to have been defective in materials workmanship, if the defect materially impairs the value of the equipment to Buyer. Oliver Packaging & Equipment has no obligation as to parts or components not manufactured by Oliver Packaging & Equipment, but Oliver Packaging & Equipment assigns to Buyer any warranties made to Oliver Packaging & Equipment by the manufacturer thereof.

This warranty **does not** apply to:
1. Damage caused by shipping or accident.
2. Damage resulting from improper installation or alteration.
3. Equipment misused, abused, altered, not maintained on a regular basis, operated carelessly, or used in abnormal conditions.
4. Equipment used in conjunction with products of other manufacturers unless such use is approved by Oliver Packaging & Equipment in writing.
5. Periodic maintenance of equipment, including but not limited to lubrication, replacement of wear items, and other adjustments required due to installation, set up, or normal wear.
6. Losses or damage resulting from malfunction.

The foregoing warranty is in lieu of all other warranties expressed or implied AND OLIVER PACKAGING & EQUIPMENT MAKES NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR PURPOSE REGARDING THE EQUIPMENT COVERED BY THIS WARRANTY. Oliver Packaging & Equipment neither assumes nor authorizes any person to assume for it any other obligations or liability in connection with said equipment. OLIVER PACKAGING & EQUIPMENT SHALL NOT BE LIABLE FOR LOSS OF TIME, INCONVENIENCE, COMMERCIAL LOSS, INCIDENTAL OR CONSEQUENTIAL DAMAGES.

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WARRANTY PROCEDURE

1. If a problem should occur, either the dealer or the end user must contact the Customer Service Department and explain the problem.

2. The Customer Service Manager will determine if the warranty will apply to this particular problem.

3. If the Customer Service Manager approves, a Work Authorization Number will be generated, and the appropriate service agency will perform the service.

4. The service dealer will then complete an invoice and send it to the Customer Service Department at Oliver Packaging & Equipment Company.

5. The Customer Service Manager of Oliver Packaging & Equipment Company will review the invoice and returned parts, if applicable, and approve for payment.

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RETURNED PARTS POLICY

This policy applies to all parts returned to the factory whether for warranted credit, replacement, repair or re-stocking.

Oliver Packaging & Equipment Company requires that the customer obtain a Return Material Authorization (RMA) number before returning any part. This number should appear on the shipping label and inside the shipping carton as well. All parts are to be returned prepaid**.** Following this procedure will insure prompt handling of all returned parts.

To obtain an RMA number contact the Repair Parts Deptartment toll free at (800) 253-3893.

Parts returned for re-stocking are subject to a **RE-STOCKING CHARGE**.

Thank you for your cooperation,

Repair Parts Manager
Oliver Packaging & Equipment Company